

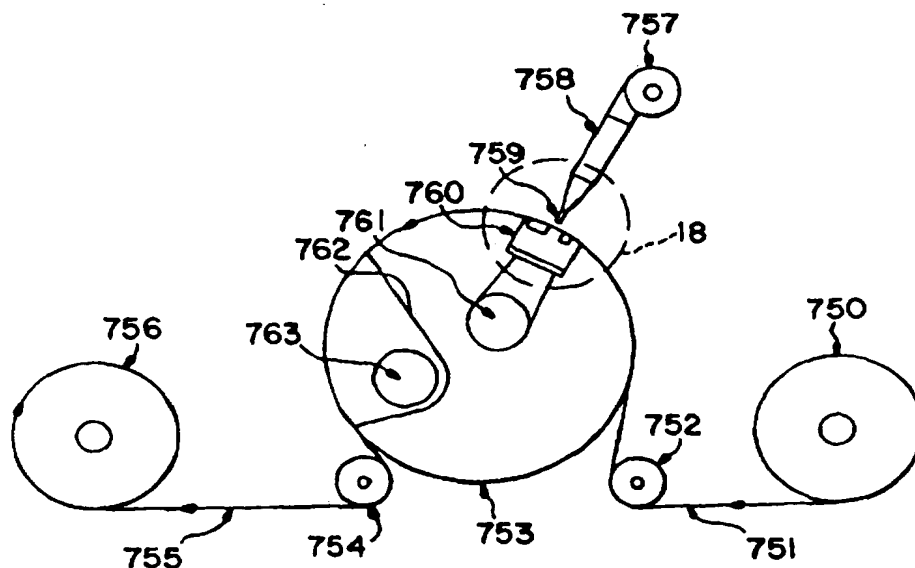
## INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

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<b>(21) International Application Number:</b> PCT/US96/02728 <b>(22) International Filing Date:</b> 22 February 1996 (22.02.96) <b>(30) Priority Data:</b> 08/574,252                      18 December 1995 (18.12.95)      US <b>(71) Applicant:</b> McNEIL-PPC, INC. [US/US]; Grandview Avenue, Skillman, NJ 08558 (US). <b>(72) Inventors:</b> JAMES, William, A.; 551 Scotch Road West, Pennington, NJ 08534 (US). BREITKOPF, Stephen; 447 Barrymore Place, North Brunswick, NJ 08902 (US). KELLY, William, G.; 10 Wilton Avenue, Middlesex, NJ 08846 (US). <b>(74) Agents:</b> CIAMPORCERO, Audley, A., Jr. et al.; Johnson & Johnson, One Johnson & Johnson Plaza, New Brunswick, NJ 08933 (US).		<b>(81) Designated States:</b> AL, AM, AT, AU, AZ, BB, BG, BR, BY, CA, CH, CN, CZ, DE, DK, EE, ES, FI, GB, GE, HU, IS, JP, KE, KG, KP, KR, KZ, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, TJ, TM, TR, TT, UA, UG, UZ, VN, ARIPO patent (KE, LS, MW, SD, SZ, UG), Eurasian patent (AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, DE, DK, ES, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG).  <b>Published</b> <i>With international search report.</i>

**(54) Title:** LASER DRILLING PROCESSES FOR MAKING FABRIC AND FILM FORMING DEVICES

**(57) Abstract**

Support members and method of forming support members for use in producing nonwoven fabrics, especially tricot-like nonwoven fabrics, and films. A topographical support member includes a body having a top surface comprising a pattern of a plurality of peaks and valleys and a plurality of apertures. The apertures have a conical top portion that is surrounded by a cluster of the peaks and valleys. The center line to center line spacing of adjacent apertures is less than the major diameter of the conical top portion of the apertures. The topographical support member is formed in a defocused process by focusing a laser beam so that the focal point is below the top surface of a starting workpiece and drilling with the laser beam the predetermined pattern of tapered apertures. The pattern of tapered apertures forms the cluster of peaks and valleys surrounding each aperture on the top surface of the resulting support member. A smooth, flat surface support member is formed by focusing the laser beam at the top surface of the workpiece or by adjusting the center line to center line spacing of apertures formed by the defocused process so that no peaks or valleys result. A perforated film or nonwoven fabric can be formed using the smooth surface support member.



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LASER DRILLING PROCESSES FOR MAKING  
FABRIC AND FILM FORMING DEVICES

RELATED APPLICATIONS

5 This application is a continuation-in-part of commonly assigned U.S. application Serial No. 08/307,203, filed September 16, 1994, which is a continuation-in-part of commonly assigned U.S. application Serial No. 08/131,191, filed September 13, 1993.

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BACKGROUND OF THE INVENTION

Nonwoven fabrics have been known for many years. In one process for producing nonwoven fabrics, a fiber batt or web is treated with water streams to cause the fibers to entangle with each other and provide some strength in the batt. Many methods have been developed for treating fiber batts in this manner in an attempt to duplicate the physical properties and appearance of woven fabrics.

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20 U.S. Patents 5,098,764 and 5,244,711 disclose backing members for supporting a fibrous web during the manufacture of nonwoven fabrics. The support members disclosed in U.S. 5,098,764 have a predetermined topography as well as a predetermined pattern of openings within that topography. In one specific embodiment, the backing member is three-dimensional and includes a plurality of pyramids disposed in a pattern over one surface of the backing member. This specific backing member further includes a plurality of openings which are disposed in the spaces, referred to as "valleys", between the aforementioned pyramids. In this process, a starting web of fiber is positioned on the topographical support member. The support member with the fibrous web thereon is passed under jets of high pressure fluid, typically water. The jets of water cause the fiber to intertwine and interentangle with

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each other in a particular pattern, based on the topographical configuration of the support member.

5 The pattern of topographical features and apertures in the support member is critical to the structure of the resulting nonwoven fabric. In addition, the support member must have sufficient structural integrity and strength to support a fibrous web while fluid jets rearrange the fibers and entangle them in their new  
10 arrangement to provide a stable fabric. The support member must not undergo any substantial distortion under the force of the fluid jets. Also, the support member must have means for removing the relatively large volumes of entangling fluid so as to prevent "flooding"  
15 of the fibrous web, which would interfere with effective entangling. Typically, the support member includes drainage apertures which must be of a sufficiently small size to maintain the integrity of the fibrous web and prevent the loss of fiber through the forming surface.  
20 In addition, the support member should be substantially free of burrs, hooks or the like irregularities that could interfere with the removal therefrom of the entangled fabric. At the same time, the support member must be such that fibers of the fibrous web being  
25 processed thereon are not washed away under the influence of the fluid jets.

While machining may be used to fabricate such topographical support members, such a method of  
30 manufacture is extremely expensive and often results in aforementioned burrs, hooks and irregularities. Thus, there is a need for a method for making topographical support members which method is less expensive and

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reduces the numbers of burrs, hooks and irregularities therein.

5 Vacuum perforated plastic films are well known in the art and have been used for many years as a cover stock for sanitary napkins, disposable diapers, and assorted absorbent products for wound dressings and the like.

10 An exemplary method and apparatus for vacuum perforating of unperforated thermoplastic film, e.g., a polyethylene film, is disclosed in U.S. Patent No. 4,806,303 issued to Bianco et al. on February 21, 1989, the disclosure of which patent is hereby incorporated by reference. The perforation apparatus of Bianco et al. comprises a  
15 generally cylindrical metallic forming die having a plurality of holes therein. In general, the plurality of holes in the forming die corresponds to the pattern of perforating which is intended to be provided in the thermoplastic film. Such forming dies were typically  
20 made by techniques which involved photoengraving, electrodeposition of nickel and mechanical perforation. This type of forming die had a thickness on the order of a millimeter or even less, a diameter on the order of 500 millimeters and a length on the order of a meter or  
25 more. In view of the foregoing dimensions, such forming dies lacked intrinsic rigidity. Prior to the development of Bianco et al., such forming dies were supported by means of an internal stiffening drum or cylinder. Among other things, such internally located  
30 support members tended to limit the pattern of perforations which could be provided in the forming die and/or obstructed the flow of air through the vacuum forming apparatus during manufacture of the perforated film. Bianco et al. provides a rotatable cylindrical

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body 4 comprising a perforated band 6, which functions as the forming die, and a pair of annular end bodies 5 each of which includes a circular flanged edge 9. Each circular flanged edge 9 is toothed and meshes with a motor driven wheel 11. Axially adjustable jaw members 13, 14 at each end of the rotatable cylinder 4 engage the aforementioned pair of flanged edges and exert a pulling action on the cylindrical body to cause what is described as a "dynamic" stiffening of die 6. As a result of this dynamic stiffening, die 6 behaves as a rigid body capable of rotating about its longitudinal axis without being subjected to considerable torsional stresses. This dynamic stiffening also prevents excessive flexing of the die 6 into the vacuum slot of the vacuum forming apparatus. The jaw arrangement which provides the dynamic stiffening of the cylindrical body in Bianco et al. not only requires maintenance and adjustment, but adds appreciably to the stresses to which the forming die is subjected, dramatically reducing its life.

#### SUMMARY OF THE INVENTION

The present invention is directed to a method of forming support members which can be used to produce nonwoven fabrics and apertured films. Such support members may have either a smooth or a topographical top, or outer, surface. The invention is also directed to a topographical support member which is formed by the method of the invention which can be used to produce tricot-like or other similar nonwoven fabrics.

In accordance with the method of the present invention, a laser beam is directed onto a workpiece. In one embodiment, the laser beam is focused such that the

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focal point of the beam is below the top surface of the workpiece. The focusing of the laser beam at a point other than the top surface of the workpiece, e.g. at a point below the top surface, instead of on the surface is termed "defocusing." Thereafter, the defocused laser beam is used to drill a predetermined pattern of tapered apertures in the workpiece in such a manner to form a topographical array of peaks and valleys surrounding each aperture of the workpiece. The apertures have a tapered or conical-like top portion angled such that the major diameter of the aperture resides on the top surface of the resulting support member. The topographical array of peaks and valleys is formed by the center line to center line spacing of adjacent apertures being less than the major diameter of the top portion of the apertures. Such a spacing results in the taper of adjacent apertures intersecting within the starting thickness of the workpiece.

In another embodiment, the laser beam is focused on the top surface of the workpiece, resulting in a smooth, flat top surface support member with a pattern of apertures.

In one embodiment, a raster scan laser drilling process is used to form the support members. In this embodiment, the laser beam is moved in a series of raster scans over the surface of the workpiece. During each scan, the laser is turned on at predetermined intervals of sufficient time and intensity to drill one or more discrete portions of each of the apertures. In this method, each aperture will take a multiplicity of scans to be drilled in its entirety.

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In one embodiment, the pattern of the plurality of peaks, valleys and apertures is configured to produce a nonwoven fabric having the appearance of a tricot knit fabric. In another embodiment, a perforated film is formed using an apertured support member having a smooth top surface.

#### BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 is a perspective view of one type of topographical support member of the present invention.

Figure 2 is a cross-sectional view taken along lines 2-2 of Figure 1.

Figure 3 is a bit map of the laser instructions defining a pattern of apertures to be drilled in a workpiece to form the topographical support member of Figure 1.

Figure 4 is a diagrammatic view of an apparatus for forming a support member of the present invention.

Figure 5 depicts the smallest rectangular repeat element, 25 pixels long and 15 pixels wide, of the pattern shown in Figure 3.

Figure 6 is a block diagram showing the various steps of the process of producing nonwoven fabrics using a support member of the present invention.

Figure 7 is a schematic sectional view of one type of apparatus for producing nonwoven fabrics using a support member of the present invention.



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Figure 8 is a diagrammatic view of another type of apparatus for producing nonwoven fabrics using a support member of the present invention.

5 Figure 9 is a diagrammatic view of a preferred type of apparatus for producing nonwoven fabrics using a support member of the present invention.

10 Figure 10 is a photomicrograph of a tricot-like nonwoven fabric, enlarged about 20 times, as seen from its upper surface, formed using the topographical support member of Figure 1.

15 Figure 11 is a photomicrograph of the tricot-like nonwoven fabric of Figure 9 as seen from its bottom surface.

20 Figure 12 is a bit map, similar to that depicted in Figure 3, of a different set of laser instructions.

Figure 13 is a digitized image of a support member of the present invention from a scanning electron microscope.

25 Figure 14 is another digitized image of the support member shown in Figure 13.

30 Figure 15 is a perspective view of a second type of support member of the present invention.

Figure 16 is a cross-sectional view taken along lines 16-16 of Figure 15.

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Figure 17 is a diagrammatic view of a preferred type of apparatus for producing apertured film using a support member of the present invention.

5 Figure 18 is an enlarged view of the circled area in Figure 17.

Figure 19 is a perspective view of a third type of support member of the present invention.

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Figure 20 is a cross-sectional view taken along lines 20-20 of Figure 19.

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Figure 21 is a repeat element of a bit map for defining a pattern of apertures to be drilled to form the support member of Figure 15.

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Figure 22 is a photomicrograph of the top surface of the apertured film produced in Example 4.

#### DETAILED DESCRIPTION OF THE INVENTION

Referring now to the drawings, a topographical support member of the present invention is shown in perspective in Figure 1.

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The support member 2 comprises a body 1 having a top surface 3 and bottom surface 4. Disposed in a predetermined pattern across top surface 3 is an array of peaks 5 separated by valleys 6. A plurality of drainage apertures 7 extending through the thickness of the support member are disposed in a pattern in the member 2. In this embodiment, each drainage aperture 7 is surrounded by a cluster of six peaks 5 and six valleys 6.

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Drainage aperture 7 comprises an upper portion 7a and a lower portion 7b. As can be seen in Figure 1, upper portion 7a of aperture 7 comprises a wall 10 and is generally "bell-mouthed" or "flared" in configuration.

5 Upper portion 7a is tapered, having a cross-sectional area which is larger nearer the top surface of support member 2 and a cross-sectional area which is smaller at the point 10a where the bottom of said upper portion meets the top of lower portion 7b. Lower portion 7 b,  
10 in the specific embodiment under discussion, has a somewhat tapered cylindrical configuration. The cross-sectional area of lower portion 7b of aperture 7 is greater at point 10a than at the bottom surface 4 of the support member. An aperture 7 is shown in cross-section  
15 in Figure 2. Lines 9 are drawn tangent to opposed points on walls 10 one hole radius below top surface 3. The angle 11 formed by lines 9 must be controlled relative to the thickness 12 of the support member 2 to produce the intended result. For example, if the angle  
20 is too great, the aperture will be too small and therefore insufficient drainage will be provided. If the angle is too small, there will be very few or no peaks and valleys.

25 The center-to-center spacing, S, of adjacent apertures (See Fig. 1) in the repeating pattern is of similar importance. The peaks 5 and valleys 6 are created by the intersection of the tapered somewhat conical apertures 7. If the center-to-center spacing of the  
30 apertures were greater than the major diameter of aperture 7 at the top surface 3, no intersection would result, and the member would be a smooth, flat top surface with conical apertures disposed throughout. Referring to Figure 13, the major diameter of aperture

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A' extends between peaks 501 and 504 and is identified by double-headed arrow 521. Similarly, the major diameter of aperture B' extends between peaks 503 and 512 and is identified by double-headed arrow 522. The major diameter of a given aperture is the largest peak-to-peak distance, measured at the top surface of the support member, between any pair of peaks defining the upper portion of the aperture. When the center-to-center spacing of adjacent apertures is less than the aperture diameters measured along that center-to-center line, the conical surfaces intersect forming a valley.

Referring now to Figure 3, apertures 7 are depicted as hexagons in a nested array, but the invention is not limited to hexagons. Other shapes, such as for example circles, squares, octagons, or irregular shapes (See Fig. 12), or combinations thereof, may be used, depending on the desired topographical configuration.

Rows 13 and 14, running parallel to directional arrow A in Fig. 3, each comprise a plurality of hexagons 150. These hexagons are 7 pixels wide, 11 pixels long and within each row are spaced 8 pixels apart. Row 13 of hexagons is spaced closely to row 14 of hexagons. Specifically, as can be seen in Fig. 3, the lower tip of each hexagon in row 13 is tangent to line 17, which line 17 is also tangent to the upper tip of each hexagon in row 14. Rows 15 and 16 duplicate the pattern and spacing of rows 13 and 14. The spacing between rows 15 and 16 corresponds substantially to the above-mentioned spacing between rows 13 and 14. Row 15, however, is spaced from row 14. As seen in Fig. 3, the lowermost tips of the hexagons in row 14 are tangent to line 18, while the uppermost tips of the hexagons in row 15 are

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tangent to line 19. Lines 18 and 19 are spaced from each other by a distance,  $d$ , which in the pattern illustrated in Fig. 3, is 3 pixels. The above-described pattern of the rows 13, 14, 15 and 16 is repeated throughout the bit map of Figure 3. It will be understood that the spacing of the hexagons may be non-uniform within a given row or between adjacent rows.

The distance between parallel adjacent walls 20 of two adjacent hexagons shown in the bit map of Fig. 3 must be sufficient to give the support member strength to resist the fluid forces and allow normal handling.

Referring to Figure 1, each aperture 7 is surrounded by six adjacent apertures 7. If all of these apertures 7 have sufficient taper to create diameters greater than their respective center-to-center spacing, each aperture 7 will have six intersections with its neighbors, and these intersections will produce six valleys 6. Depending on their depth, these valleys 6 can either intersect the top surface 3, resulting in their being separated by small plateaus, or they can intersect each other and produce a peak 5.

The apparatus of the present invention used to produce topographical support members is shown in Figure 4. The starting material for the support member may be any desired shape or composition. The topographical support member preferably comprises acetal; acrylic will also perform satisfactorily. In addition, the preferred shape of the starting material is a thin wall, cylindrical, preferably seamless, tube that has been relieved of residual internal stresses. As will be

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described later, the cylindrical shape accommodates the preferred apparatus for producing the nonwoven fabrics.

5 Tubes manufactured to date for use in forming support members are 2 to 6 feet in diameter and have a length ranging from 2 to 16 feet. The wall thickness is nominally  $\frac{1}{4}$  inch. These sizes are a matter of design choice.

10 A starting blank tubular workpiece is mounted on an appropriate arbor, or mandrel 21 that fixes it in a cylindrical shape and allows rotation about its longitudinal axis in bearings 22. A rotational drive 23 is provided to rotate mandrel 21 at a controlled rate.  
15 Rotational pulse generator 24 is connected to and monitors rotation of mandrel 21 so that its precise radial position is known at all times.

20 Parallel to and mounted outside the swing of mandrel 21 is one or more guide ways 25 that allow carriage 26 to traverse the entire length of mandrel 21 while maintaining a constant clearance to the top surface 3 of tube 2. Carriage drive 33 moves the carriage along guide ways 25, while carriage pulse generator 34 notes  
25 the lateral position of the carriage with respect to support member 2. Mounted on the carriage is focusing stage 27. Focusing stage 27 is mounted in focus guide ways 28 and allows motion orthogonal to that of carriage 26 and provides a means of focusing lens 29 relative to  
30 top surface 3. Focus drive 32 is provided to position the focusing stage 27 and provide the focusing of lens 29.

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Secured to focusing stage 27 is the lens 29, which is secured in nozzle 30. Nozzle 30 has means 31 for introducing a pressurized gas into nozzle 30 for cooling and maintaining cleanliness of lens 29.

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Also mounted on the carriage 26 is final bending mirror 35, which directs the laser beam 36 to the focusing lens 29. Remotely located is the laser 37, with optional beam bending mirrors 38 to direct the beam to final beam bending mirror 35. While it would be possible to mount the laser 37 directly on carriage 26 and eliminate the beam bending mirrors, space limitations and utility connections to the laser make remote mounting far preferable.

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When the laser 37 is powered, the beam 36 emitted is reflected first off beam bending mirror 38, then final beam bending mirror 35, which directs it to lens 29. The path of laser beam 36 is configured such that, if lens 29 were removed, the beam would pass through the longitudinal center line of mandrel 21.

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With lens 29 in position, the beam is focused below, but near the top surface 3. As indicated above, focusing the beam below the top surface is identified as "defocusing" the laser beam relative to the surface of the tube.

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While this invention could be used with a variety of lasers, the preferred laser is a fast flow CO<sub>2</sub> laser, capable of producing a beam rated at up to 2500 watts. This process is in no way dependent on such a high power laser, as support surfaces have been successfully drilled with a slow flow CO<sub>2</sub> laser rated at 50 watts.

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When focusing lens 29 passes beam 36, it concentrates the energy near the center of the beam. The rays are not bent through a single point, but rather a spot of small diameter. The point of smallest diameter is said to be the focus or focal point. This occurs at a distance from the lens said to be the focal length. At lengths either shorter or greater than the focal length, measured spot sizes will be greater than the minimum.

The sensitivity to focus position is inversely proportional to focal length. Minimum spot size is directly proportional to focal length. Therefore, a short focal length lens can achieve a smaller spot size but must be more accurately positioned and is affected dramatically by surface run-out. Longer focal length lenses are more forgiving of target positioning, but can only achieve somewhat larger spot sizes. Thus, in addition to the power distribution contributing to the tapered top portion of the drilled aperture, the defocusing of the beam below the surface also contributes to the angle and length of the taper, and hence the shape and size of the peaks and valleys.

In order to fabricate a support member, an initial focusing step must be performed. Once a blank tubular workpiece 2 is positioned on the mandrel 21, the laser is pulsed briefly and the mandrel rotated slightly between pulses such that a series of small depressions is produced. The focus stage 27 is then moved with respect to the mandrel center line to change the focus position and another series of depressions is produced. Typically a matrix of 20 rows of 20 depressions each is drilled. The depressions are examined microscopically, and the column of smallest diameter depressions



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identifies the focus stage position which focuses the beam at the top surface 3 of the blank tubular workpiece.

- 5 A desired pattern is selected, such as the one shown in Figure 3. The pattern is examined to determine the number of repeats that will be required to cover the circumference of the workpiece and complete the surface without an obvious seam. Similarly, the advance along  
10 the longitudinal axis of the tubular workpiece per repeat and total number of repeats is established. These data are entered into a computer control for operating the laser drilling machine.
- 15 In operation, the mandrel, with the tubular workpiece mounted thereon, is rotated in front of the lens. The carriage is motored so that the first aperture position corresponds with the focal point of the lens 29. The focus stage is motored inward, placing the focal point  
20 inside the interior of the material to be drilled. The laser is then pulsed, with some combination of pulse power level and duration. As seen in Figure 2, the diameter of the aperture at the top surface 3 is considerably larger than the diameter of the aperture at  
25 the lower surface 4. In order to achieve the desired topographical configuration, two factors need to be measured and controlled. First, the degree with which the lens is focused into the interior of the workpiece increases the cone angle 11, and second, increasing the  
30 power level or pulse duration increases the depth and diameter. Once an aperture of the proper diameter and taper is achieved, the rotational drive and carriage drive can be indexed to reposition the support member such that the next intended hole position corresponds to

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the focal point. The process is then repeated until the entire pattern has been drilled. This technique is known as "percussion" drilling.

5 If the laser selected is of sufficient power, the mandrel and carriage do not need to be stopped during the laser pulse. The pulse can be of such short duration that any movement of the workpiece during the drilling process is inconsequential. This is known in  
10 the trade as "fire-on-the-fly" drilling.

If the laser can recover rapidly enough, the workpiece can be rotated at a fixed speed and the laser pulsed once to create each hole. In a pattern such as the one  
15 shown in Figure 3, the laser would normally be pulsed to produce a complete column, the carriage indexed to the next column position and the beam pulsed for the next series of apertures.

20 One problem that may occur depending on the type of material and density of the pattern of apertures, is the introduction of a large amount of heat into a small area of the forming surface. Gross distortion, and the loss of pattern registration may result. Under some  
25 conditions, major dimensional changes of the part results, and the surface is neither cylindrical nor the right size. In extreme cases, the tube may crack.

30 A preferred embodiment of the present invention, which eliminates this problem, uses a process called raster scan drilling.

In this approach, the pattern is reduced to the smallest rectangular repeat element 41 as depicted in Figure 5.

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This repeat element contains all of the information required to produce the pattern in Figure 3. When used like a tile and placed both end-to-end and side-by-side, the larger pattern is the result.

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This repeat element is further divided into a grid of smaller rectangular units or "pixels" 42. Though typically square, for some purposes, it is more convenient to employ pixels of unequal proportions.

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Each column of pixels represents one pass of the workpiece past the focal position of the laser. This column is repeated as many times as is required to reach completely around support member 2. Each pixel where the laser is intended to create a hole is black. Those pixels where the laser is turned off are white.

15

To begin drilling at the top of the first column of pixels in Figure 5, while the mandrel is turning at a fixed rate, the laser is turned on, maintained at a constant power level for 11 pixels and then switched off. These pixels are counted by the rotational pulse generator 24 in Figure 4. The laser remains off for the next 14 units. This laser off/on sequence is repeated for the first revolution, at which point the mandrel is back to starting position, carriage drive 33 has repositioned the carriage one unit and the computer is ready to do column 43a.

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During column number 43a, the laser has a shorter "on time" (now 9 units) and longer "off time" (now 16 units). The total number of on and off times is a constant based on the pattern height.

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This process is repeated until all of the columns have been used over an entire revolution each; in the case of Figure 5, there were 15 revolutions of the mandrel. At this point, the process returns to the instructions in column 43.

Note that in this approach, each pass produces a number of narrow cuts in the material, rather than a large hole. Because these cuts are precisely registered to line up side-by-side and overlap somewhat, the cumulative effect is a hole. In the pattern of Figure 5, each hexagonal hole 44 actually requires 7 passes, each separated by a complete revolution, distributing the energy around the tube and minimizing local heating.

If, during this drilling operation, the lens was focused at the top surface of the material, the result would be hexagonal holes with reasonably parallel walls. The combination of raster scan drilling with the defocused lens approach, however, produces the forming surface of Figure 1.

In the present invention, the apertures 7 are quite small and numerous. Typical patterns range from 800 to 1400 apertures per square inch.

The process to manufacture a nonwoven fabric using a support member of the present invention has been described in U.S. Patents 5,098,764 and 5,244,711, both of which are incorporated by reference herein.

Figure 6 is a block diagram showing the various steps in the process of producing the novel nonwoven fabrics of the present invention. The first step in this process

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is to position a web of fibers on a topographical support member (Box 1). The fibrous web is presoaked or wetted out while on this support member (Box 2) to ensure that as it is being treated it will remain on the support member. The support member with the fibrous web thereon is passed under high pressure fluid ejecting nozzles (Box 3). The preferred fluid is water. The water is transported away from the support member, preferably using a vacuum (Box 4). The fibrous web is de-watered (Box 5). The de-watered formed fabric is removed from the support member (Box 6). The formed fabric is passed over a series of drying drums to dry the fabric (Box 7). The fabric may then be finished or otherwise processed as desired (Box 8). Figure 7 is a schematic representation of one type of apparatus for carrying out the process and producing the fabrics of the present invention. In this apparatus, a foraminous conveyor belt 70 moves continuously about two spaced apart rotating rolls 71 and 72. The belt is driven so that it can be reciprocated or moved in either a clockwise or counterclockwise direction. At one position on the belt, in the upper reach 73 of the belt, there is placed above the belt a suitable water ejecting manifold 74. This manifold has a plurality of very fine diameter holes, of about 7/1000 of an inch in diameter, with about 30 holes per inch. Water under pressure is driven through these holes. On top of the belt is placed a topographical support member 75 and on top of that topographical member the fiber web 76 to be formed is placed. Directly beneath the water manifold, but under the upper reach of the belt, is a suction manifold 77 to aid in removing the water and prevent flooding of the fiber web. Water from the manifold impinges on the fiber web, passes through the topographical support

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member and is removed by the suction manifold. As may be appreciated, the topographical support member with the fibrous web thereon may be passed under the manifold a number of times as desired to produce fabrics in accordance with the present invention.

In Figure 8 there is depicted an apparatus for continuously producing fabrics in accordance with the present invention. This schematic representation of the apparatus includes a foraminous conveyor belt 80 which actually serves as the topographical support member in accordance with the present invention. The belt is continuously moved in a counterclockwise direction about spaced apart rotating rolls as is well known in the art. Disposed above this belt is a fluid feeding manifold 79 connecting a plurality of lines or groups 81 of orifices. Each group has one or more rows of very fine diameter holes with 30 or more holes per inch. The manifold is equipped with pressure gauges 88 and control valves 87 for regulating the fluid pressure in each one or group of orifices. Disposed beneath each orifice line or group is a suction member 82 for removing excess water, and to keep the area from flooding. The fiber web 83 to be formed into the nonwoven fabric of the present invention is fed onto the topographical support member conveyor belt. Water is sprayed through an appropriate nozzle 84 onto the fibrous web to pre-wet the web and aid in controlling the fibers as they pass under the pressure manifolds. A suction slot 85 is placed beneath this water nozzle to remove excess water. The fibrous web passes under the fluid feeding manifold with the manifold preferably having an increased pressure. For example, the first lines of holes or orifices may supply fluid forces at 100 psi, while the

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next lines of orifices may supply fluid forces at a pressure of 300 psi, and the last lines of orifices supply fluid forces at a pressure of 700 psi. Though six fluid supplying lines of orifices are shown, the number of lines or rows of orifices is not critical, but will depend on the weight of the web, the speed of operation, the fluid pressures used, the number of rows of holes in each line, etc. After passing between the fluid feeding and suction manifolds the formed fabric is passed over an additional suction slot 86 to remove excess water from the web.

A preferred apparatus for producing fabrics in accordance with the present invention, is schematically depicted in Figure 9. In this apparatus, the topographical support member is a rotatable drum 90. The drum rotates in a counterclockwise direction. Drum 90 may be a continuous cylindrical drum or may be made of a plurality of curved plates 91 disposed so as to form the outer surface of the drum. In either case, the outer surface of drum 90 or the outer surfaces of the curved plates 91 comprise the desired topographical support configuration. Disposed about a portion of the periphery of the drum is a manifold 89 connecting a plurality of orifice strips 92 for applying water or other fluid to a fibrous web 93 placed on the outside surface of the curved plates. Each orifice strip may comprise one or more rows of very fine diameter holes of approximately 5/1000 of an inch to 10/1000 of an inch in diameter. There may be as many as 50 or 60 holes per inch or more if desired. Water or other fluid is directed through the rows of orifices. The pressure in each orifice group is increased from the first group under which the fibrous web passes to the last group.

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The pressure is controlled by appropriate control valves 97 and monitored by pressure gauges 98. The drum is connected to a sump 94 on which a vacuum may be pulled to aid in removing water and to keep the area from flooding. In operation, the fibrous web 93 is placed on the upper surface of the topographical support member before the water ejecting manifold 89. The fibrous web passes underneath the orifice strips and is formed into a tricot-like nonwoven fabric. The formed fabric is then passed over a section 95 of the apparatus where there are no orifice strips, but vacuum is continued to be applied. The fabric after being de-watered is removed from the drum and passed around a series of dry cans 96 to dry the fabric.

As noted above, the support member shown in Figure 1 will produce a tricot-like nonwoven fabric. Figure 10 is a copy of a photomicrograph of a tricot-like nonwoven fabric at an enlargement of approximately 20 times. The fabric 100 is made from a plurality of fibers. As seen in the photomicrograph, the fibers are intertwined and interentangled and form a pattern of openings 110 in the fabric. A number of these openings include a loop 120 formed from fiber segments. Each loop is made from a plurality of substantially parallel fiber segments. The loops are in the shape of a U with the closed end of the U pointed upwardly towards the upper surface of the fabric as viewed in the photomicrograph. Figure 11 is a copy of a photomicrograph of the opposite, i.e. bottom, surface of fabric 100 of Figure 10 at an enlargement of about 20 times. The fibers in the fabric are intertwined and entangled to form a pattern of openings 110 in the fabric. In some of these openings there are U-shaped loops 120 formed from substantially parallel



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fiber segments. When viewed from this bottom surface of the fabric, the open end of the U-shaped loop is pointed towards the surface of the fabric viewed in this photomicrograph.

5

As indicated earlier herein, a support member having a smooth, flat top surface with apertures disposed throughout can also be made by laser processing. Such a support member, identified by numeral 700, is illustrated in Figures 15 and 16. As shown in Figures 15 and 16, the support member 700 comprises a body 701 having a top surface 703 and bottom surface 704. Disposed in a predetermined pattern across top surface 703 is an array of apertures 707 extending through the thickness,  $t$ , of the body 701.

15

The support member 700 can be formed by the 'defocused' laser drilling processes described above. In the defocused case, aperture 707 will have a tapered cylindrical configuration. The cross-sectional area of apertures 707 at bottom surface 704 is smaller than the cross-sectional area of apertures 707 at top surface 703.

20

The center-to-center spacing,  $S$ , of adjacent apertures 707 is of considerable importance. If the center-to-center spacing is smaller than the diameter of apertures 707 at top surface 703, the tapered, somewhat conical apertures 707 will intersect, resulting in apertures surrounded by an array of peaks and valleys. Such an array of peaks and valleys would create similar peaks and roughness in the final perforated film. In order to form a smooth, flat top surface apertured support member, the center-to-center spacing,  $S$ , must be greater

30

- 24 -

than the major diameter of the apertures 707 at the top surface 703. The smooth, flat top surface of the support member can be used to produce a smooth, planar final apertured film or nonwoven fabric.

5

In a preferred embodiment, the smooth, flat top surface support member is formed by "focused" laser drilling.

"Focused" laser drilling is a process in which the laser beam is focused onto the top surface of a tubular

10

workpiece. The workpiece may be made of polymeric material, preferably acetal. Acrylic will also perform satisfactorily. In the focused laser drilling process,

15

using the apparatus of Figure 4, the mandrel, with the tubular workpiece mounted thereon, is rotated in front of the lens. The carriage is motored so that the first aperture position corresponds with the focal point of

20

the lens 29. The focus stage is motored inward to position the focal point of lens 29 on the top surface of the tubular workpiece to be drilled, at the reference diameter established by the focusing procedure mentioned

25

above. The drilling processes can be the same processes described earlier, namely, percussion drilling, fire-on-the-fly drilling and raster scan drilling. Raster scan drilling, as described in connection with Figures 3, 4 and 5 above, is the preferred embodiment.

30

A support member 800, illustrated in Figure 19 and 20, is made with a focused laser drilling process. As shown in Figures 19 and 20, the support member 800 comprises a body 801 having a top surface 803 and bottom surface 804. Disposed in a predetermined pattern across top surface 803 is an array of apertures 807 extending through the thickness,  $t$ , of the body 801. As indicated earlier herein, with the lens focused on the top surface

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of the workpiece, apertures 807 will have nearly parallel walls. As there will be a small taper at the top of the aperture 807, the center-to-center spacing, S, is required to be of sufficient magnitude to avoid the formation of peaks and valleys. However, this spacing, S, can be smaller than in the "defocused" laser drilling process thereby producing a support member with less top surface area and more apertures which result in a film with more apertures and hence a greater percent open area.

A preferred apparatus for producing apertured films in accordance with the present invention is schematically depicted in Figure 17. In this apparatus, the support member is a rotatable drum 753. The drum rotates in a counterclockwise direction. Positioned outside drum 753 is a hot air nozzle 759 directed so as to provide a curtain of hot air to impinge directly on the film supported by the outer surface of drum 753 which comprises a plurality of apertures 753a. Means is provided to retract hot air nozzle 759 to avoid excessive heating of the film when stopped or at low speed.

Blower 757 and heater 758 cooperate to supply hot air to nozzle 759.

Positioned inside drum 753, directly interiorly of nozzle 759, is vacuum head 760. Vacuum head 760 is radially adjustable and positioned so as to contact the interior surface of drum 753. A vacuum source 761 is provided to continuously exhaust vacuum head 760.

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In addition, in the interior of drum 753, and contacting the inner surface of drum 753, is cooling zone 762 which has been provided with cooling vacuum source 763. In cooling zone 762, this vacuum source 763 draws ambient air through the apertures made in the hot film to solidify the film and set the pattern created in the aperturing zone. It is important to provide this cooling before trying to remove the film from the support member in order to avoid distortion. Vacuum source 763 also provides means of holding the film in place in cooling zone 762 on drum 753, and provides means to isolate the hot film from the effects of tension in the film produced by the winder.

Also shown in Figure 17 is film supply roll 750 and finished film roll 756.

Placed on top of the backing member 64 is a thin, continuous, uninterrupted stretchable film 67 of thermoplastic polymeric material. This film may be vapor permeable or vapor impermeable; it may be embossed or unembossed; it may, if desired, be corona-discharge treated on one or both of its major surfaces or it may be free of such corona discharge treatment. The stretchable film may comprise any thermoplastic polymeric material including, by way of example, polyolefins, such as polyethylene (high, linear low or low density) and polypropylene; copolymers of olefins and vinyl monomers, such as copolymers of ethylene and vinyl acetate or vinyl chloride; polyamides; polyesters; polyvinyl alcohol and copolymers of olefins and acrylate monomers such as copolymers of ethylene and ethyl acrylate and EMA (ethylenemethylacrylate). Film comprising mixtures of two or more such polymeric

-27-

materials may also be used. The machine direction (MD) and cross direction (CD) elongation of the starting film to be apertured should be at least 100% as determined according to ASTM Test No. D-882 as performed on a

5 Instron test machine run at a jaw speed of 50 inches/minute (127 cm/minute). The thickness of the starting film (i.e. the film to be apertured) is preferably uniform and may range from about 0.5 to 3 mils or about 0.0005 inch (0.0013 cm) to about 0.005

10 inch (0.076 cm). Co-extruded films can be used as can films which have been modified, e.g. by treatment with a surface active agent. The starting film can be made by any known technique such as casting, extrusion or blowing.

15 An enlargement of the circled area of Figure 17 is shown in Figure 18. Vacuum head 760 has two vacuum slots 764, 765 extending across the width of the film. Vacuum slot 764 provides a hold down zone for the starting film as

20 it approaches air knife 758. Vacuum slot 765 is connected to a source of vacuum by a passageway 766. This anchors the incoming film 751 securely to drum 753 and provides isolation from the effects of tension in the incoming film induced by the unwind. It also

25 flattens film 751 on the outer surface of drum 753. The second vacuum slot 765 defines the vacuum aperturing zone. Immediately between slots 764 and 765 is intermediate support bar 768.

30 Vacuum head 760 is positioned such that the impingement point of hot air curtain 767 is directly above intermediate support bar 768. The hot air is provided

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at a sufficient temperature to raise the temperature of the film above its softening point.

5 The geometry of the apparatus ensures that film 751, when softened by hot air curtain 767, is isolated from tension effects by hold down slot 764 and cooling zone 762. Vacuum aperturing zone 765 is immediately adjacent hot air curtain 767, which minimizes the time in which the film is hot and prevents excessive heat transfer to support drum 753.

#### EXAMPLE 1

15 A support member having peaks and valleys and made of acetal with an average thickness of 6mm was produced using a defocused raster scan laser drilling process under the following conditions:

Focus Position = 2.5 mm below material surface

Lens Type = Positive Meniscus

20 Lens Focal Length = 5 inches

Laser Power = 1300 watts

Surface Speed of Tube on Mandrel = 20.3 m/min

Longitudinal Carriage Advance/Rev = 0.05 mm

Pixel Size = 0.05 mm

25 Center-to-Center Line Spacing Within  
a Row = 0.75 mm (15 pixels)

30 The support member made in Example 1 is shown in Figure 13 and 14. Figure 12 is a pixel-by-pixel depiction of the on/off laser power pattern programmed into the computer control used in example 1. The pattern consisted of repeating pairs of rows of apertures, labeled A<sub>1</sub>, B<sub>1</sub>, A<sub>2</sub>, B<sub>2</sub>, etc. The apertures in each A row have a first irregular shape and the apertures in each B

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row have a second irregular shape. A tubular workpiece approximately 3 feet in diameter, 12 feet long and 6 mm thick was laser drilled using the apparatus of Figure 4 operated according to the instructions contained in Figure 12 to provide the support member shown in Figures 13 and 14. The laser drilling process took about 7 days to complete.

In Figure 13, the illustrated support member comprises a first row A of apertures (seen in the upper part of Figure 13), a next adjacent row B of apertures and a second row A of apertures below row B of apertures. First row A of apertures includes aperture A'. Next adjacent row B of apertures includes aperture B' which is adjacent to aperture A'. The upper portion of aperture A' is surrounded and defined by peaks 501, 502, 503, 504, 505 and 506. The upper portion of aperture B' is surrounded and defined by peaks 510, 511, 512, 513, 504 and 503. It will be recognized that peaks 504 and 503 are common to both of apertures A' and B'. Line 521 (Double arrowhead) extending between peaks 501 and 504 constitutes the major diameter of the upper portion of aperture A', said major diameter being 0.085 inch in the support member being described. Similarly, line 522 extending between peaks 503 and 512 constitutes the major diameter of the upper portion of aperture B', said major diameter being 0.075 inch in the support member being described.

The various peak-to-peak distances associated with aperture A' in the support member being discussed are set forth in Table I. The various peak-to-peak distances associated with aperture B' in the support member are set forth in Table II.

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TABLE I  
(Dimensions in inches)

PEAK No.	501	502	503	504	505
501	---	---	---	---	---
502	0.037	---	---	---	---
503	0.067	0.040	---	---	---
504	0.085	0.067	0.037	---	---
505	0.070	0.075	0.055	0.035	---
506	0.035	0.056	0.065	0.065	0.040

TABLE II  
(Dimensions in inches)

PEAK No.	510	511	512	513	503
510	---	---	---	---	---
511	0.037	---	---	---	---
512	0.062	0.035	---	---	---
513	0.065	0.056	0.037	---	---
503	0.035	0.066	0.075	0.063	---
504	0.055	0.067	0.055	0.037	0.037

Figure 14 is the same digitized image as that shown in Figure 13 but it has been marked and numbered to show the distance between the bottom of a valley between two adjacent peaks and a line connecting the same two peaks. For example, line 530 in Figure 14 connects peaks 503 and 504 associated with aperture A'. The depths of the valleys between peaks 501-506 associated with aperture



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A' are shown in the upper portion of Table III. The depths of the 2 valleys associated with aperture B', i.e. the valleys between peaks 510 and 511 and the valley between peaks 504 and 513, are shown in the lower portion of Table III. The valleys between the remaining peaks associated with aperture B', those between peaks 511 and 512, and between 512 and 513, are structurally analogous Table III to those valleys between peaks 501 and 506, and 501 and 502 respectively.

TABLE III

Valley Between Peaks	Valley Depth Inches
501 and 502	0.016
502 and 503	0.020
503 and 504	0.024
504 and 505	0.025
505 and 506	0.020
506 and 501	0.012
510 and 511	0.026
504 and 513	0.026

**EXAMPLE 2**

A support member having a smooth, flat top surface and made of acetal with an average thickness of 6mm was produced using a defocused raster scan laser drilling process under the following conditions:

Focus Position = 2.5 mm below material surface  
Lens Type = Positive Meniscus  
Lens Focal Length = 5 inches

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Laser Power = 1300 watts  
Surface Speed of Tube on Mandrel = 20.4 m/min  
Longitudinal Carriage Advance/Rev = 0.05 mm  
Pixel Size = 0.05 mm  
Center-to-Center Line Spacing Within  
a Row = 1.5 mm (30 pixels)

The support member in Example 2, shown in Figures 15 and 16, was produced by the defocused raster scan drilling process of Example 1 except with a different raster scan pattern. The raster scan pattern used in Example 2 is shown in Figure 21, where each pixel 710 for which the laser is intended to create a hole is black and each pixel 712 where the laser is turned off is white.

### EXAMPLE 3

A support member having a smooth, flat top surface and made of acetal with an average thickness of 3 mm was produced using a focused raster scan laser drilling process under the following conditions:

Focusing Position = 0 (at top surface)  
Lens Type = Positive Meniscus  
Lens Focal Length = 5 inches  
Laser Power = 1300 watts  
Surface Speed of Tube on Mandrel = 17.4 m/min  
Longitudinal Carriage Advance/Rev = 0.05 mm  
Pixel Size = 0.05 mm  
Center-to-Center Line Spacing Within  
a Row = 0.75 mm (15 pixels)

The support member in Example 3 is of the type shown in Figures 19 and 20 and was made using the patterns shown

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in Figures 3 and 5 and with the raster scan drilling process described above using the apparatus of Figure 4.

#### EXAMPLE 4

5 A perforated film was made using the support member produced in Example 3 in combination with the apparatus shown in Figure 17. This apparatus is similar to that disclosed in U.S. Patent No. 4,806,303 issued to Bianco et al.

10

The roll of starting film 750, a 1 mil. low density polyethylene cast film, was positioned on a tension controlled unwind stand commonly used in the diaper and sanitary napkin industries. The film was then threaded  
15 around the support member 753 in Figure 17, and led to a tension controlled winder, where the finished product was collected on roll 756.

20

Nozzle 759 was retracted to avoid heating the film until operating conditions were established. Air blower 757 was started, and heater 758 powered, and adjusted until the temperature of the air exiting nozzle 759 reached 225 degrees centigrade.

25

Vacuum source 761 was started, and adjusted to hold the film securely on the support member. The drive system was then started, and the support member was rotated with a surface speed of 25 meters per minute.

30

Nozzle 759 was then advanced so that the hot air exiting nozzle 759 directly impinged the film surface between hold down zone 764 and vacuum aperturing zone 765.

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The temperature of the hot air 767 was then increased until the desired degree of aperturing was obtained. Final air temperature was 305 degrees C.

- 5 The vacuum head 760 was measured at operating conditions and found to have a suction of 365 mm Hg.

10 The hot, now apertured film continued on support member 753 to cooling zone 762 where ambient air was drawn through the apertures in the film, the holes in the support member and into the cooling vacuum source 763.

15 By the time the film reached the end of cooling zone 762, it had cooled sufficiently to be removed from the support member and wound onto roll 756.

The top surface of the apertured film produced in Example 4 is shown in the photomicrograph of Figure 22.

20 While several embodiments and variations of the present invention are described in detail herein, it should be apparent that the disclosure and teachings of the present invention will suggest many alternative designs to those skilled in the art.

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WHAT IS CLAIMED IS:

1. A method for forming a smooth surface, apertured support member for producing a planar, apertured, film or non-woven fabric comprising the steps of:
  - 5 a) providing a workpiece,
  - b) directing a laser beam toward said workpiece; and
  - c) moving the laser beam in a series of raster scans over the surface of the workpiece for drilling  
10 with said laser beam a predetermined pattern of apertures through said workpiece thereby forming a smooth surface surrounding each aperture on the top surface of the resulting support member.
- 15 2. The method of claim 1 further including the step of focusing the laser beam such that the focal point is at the top surface of the workpiece.
- 20 3. The method of claim 2 wherein said drilling step includes pulsing the laser beam in a predetermined sequence of on and off states.
- 25 4. The method of claim 2 wherein the laser beam on states are of sufficient time and intensity to drill one or more discrete units of said apertures in each raster scan.
- 30 5. The method of claim 1 wherein the step of moving the laser beam includes rotating said workpiece about its longitudinal axis and indexing the laser beam along said longitudinal axis after each revolution of the workpiece.

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6. The method of claim 1 further including the step of focusing the laser beam such that the focal point is below the top surface of said workpiece.

5 7. The method of claim 6 wherein said drilling step includes pulsing the laser beam in a predetermined sequence of on and off states.

10 8. The method of claim 6 wherein the laser beam on states are of sufficient time and intensity to drill one or more discrete units of said apertures in each raster scan.

15 9. The method of claim 2 wherein the step of moving the laser beam includes rotating said workpiece about its longitudinal axis and indexing the laser beam along said longitudinal axis after each revolution of the workpiece.

20 10. The method of claim 6 wherein the step of moving the laser beam includes rotating said workpiece about its longitudinal axis and indexing the laser beam along said longitudinal axis after each revolution of the workpiece.

25 11. The method of claim 2 wherein each aperture has substantially parallel sidewalls.

30 12. The method of claim 6 wherein each aperture is tapered and includes a conical top portion.

13. The method of claim 12 wherein the center line to center line spacing of adjacent apertures is greater

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than the major diameter of the conical top portion of each adjacent aperture.

14. An apparatus for producing an apertured film  
5 comprising:

a rotatable hollow drum having a peripheral wall made of a polymeric material, said wall having a plurality of apertures therein;

10 means for positioning a stretchable thermoplastic film on the top surface of said wall;

means for directing hot air against said film on said top surface of said wall to raise the temperature of said film above its thermoplastic temperature;

15 means for rotating said drum while the hot air is being directed against said top surface;

vacuum means disposed inside said drum to create a sufficient pressure to cause apertures to be formed in said film corresponding to the plurality of apertures in said wall;

20 means for cooling said apertured film to a temperature below its thermoplastic temperature; and

means for removing said apertured film from said drum.

25 15. The apparatus of claim 14 wherein said wall is made of a thermoplastic material.

16. The apparatus of claim 14 wherein said wall is made of acetal or acrylic.

30

17. An apparatus for producing a planar apertured film comprising:

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a rotatable hollow drum having a smooth, flat top surface and a plurality of apertures, said drum being formed by the method of claim 1;

5 means for positioning a stretchable thermoplastic film on the top surface of the drum;

means for directing hot air against said film on said top surface of said drum to raise the temperature of said film above its softening temperature;

10 means for rotating said drum while the hot air is being directed against said top surface;

vacuum means disposed inside said drum to create a sufficient pressure to cause apertures to be formed in said film corresponding to the plurality of apertures in said drum;

15 means for cooling said apertured film to a temperature below its softening temperature; and

means for removing said apertured film from said drum.

20 18. The apparatus of claim 17 wherein said drum is made of a polymeric material.

19. The apparatus of claim 18 wherein said drum is made of acetal or acrylic.

25 20. A method for producing an apertured film comprising:

30 means for positioning a stretchable thermoplastic film on the top surface of a rotatable hollow drum having a peripheral wall made of a polymeric material, said wall having a plurality of apertures;

directing hot air against said film on said top surface of said drum to raise the temperature of said film above its softening temperature;



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rotating said drum while the hot air is being directed against said top surface;

creating a sufficient pressure inside said drum to cause apertures to be formed in said film corresponding to the plurality of apertures in said drum;

cooling said apertured film to a temperature below its softening temperature; and

removing said apertured film from said drum.

21. A method for producing a planar apertured film comprising:

means for positioning a stretchable thermoplastic film on the top surface of a rotatable hollow drum having a smooth, flat top surface and a plurality of apertures, said drum being formed by the method of claim 1;

directing hot air against said film on said top surface of said drum to raise the temperature of said film above its softening temperature;

rotating said drum while the hot air is being directed against said top surface;

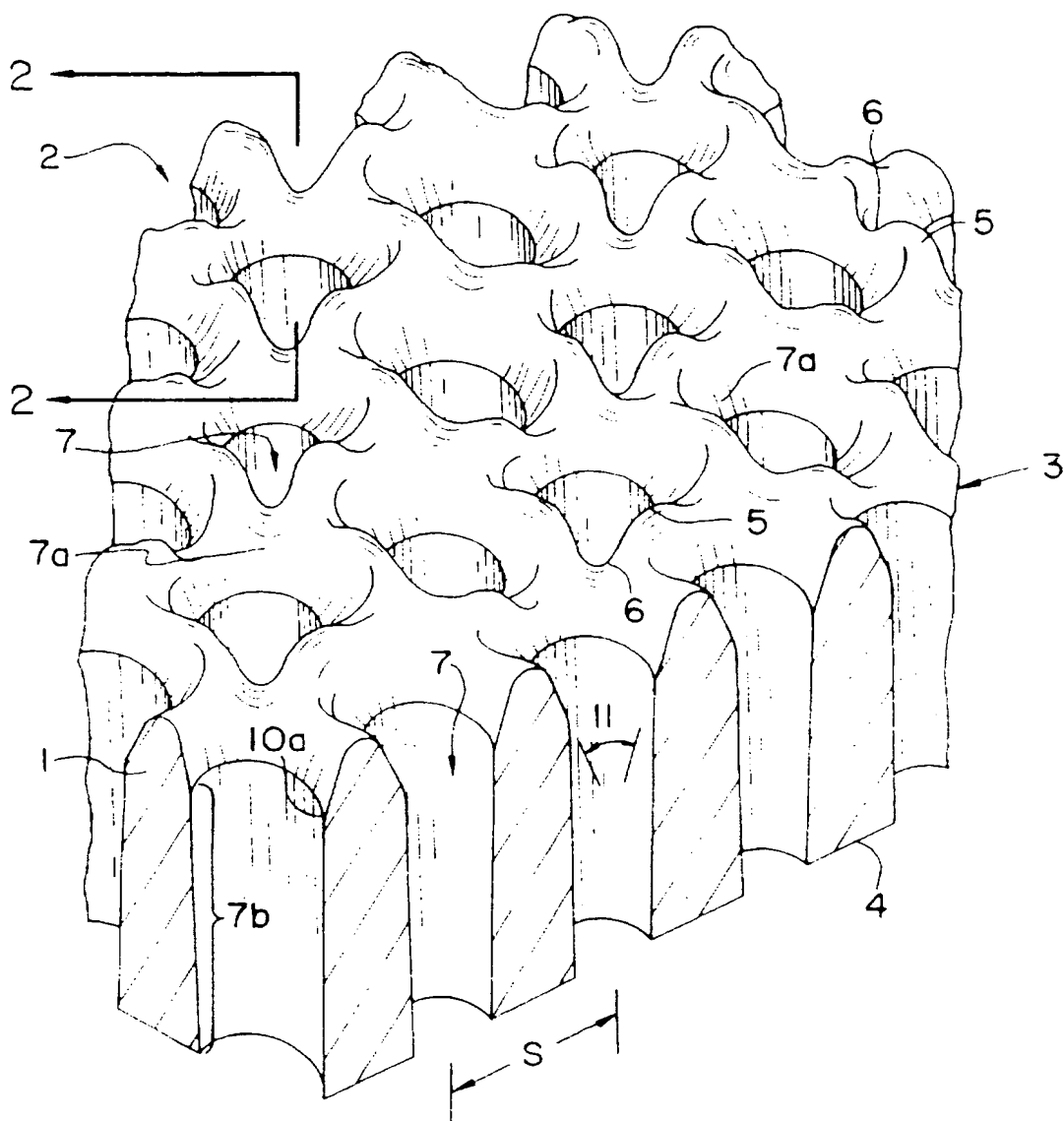
creating a sufficient pressure inside said drum to cause apertures to be formed in said film corresponding to the plurality of apertures in said drum;

cooling said apertured film to a temperature below its softening temperature; and

removing said apertured film from said drum.

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FIG. 1



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FIG.2

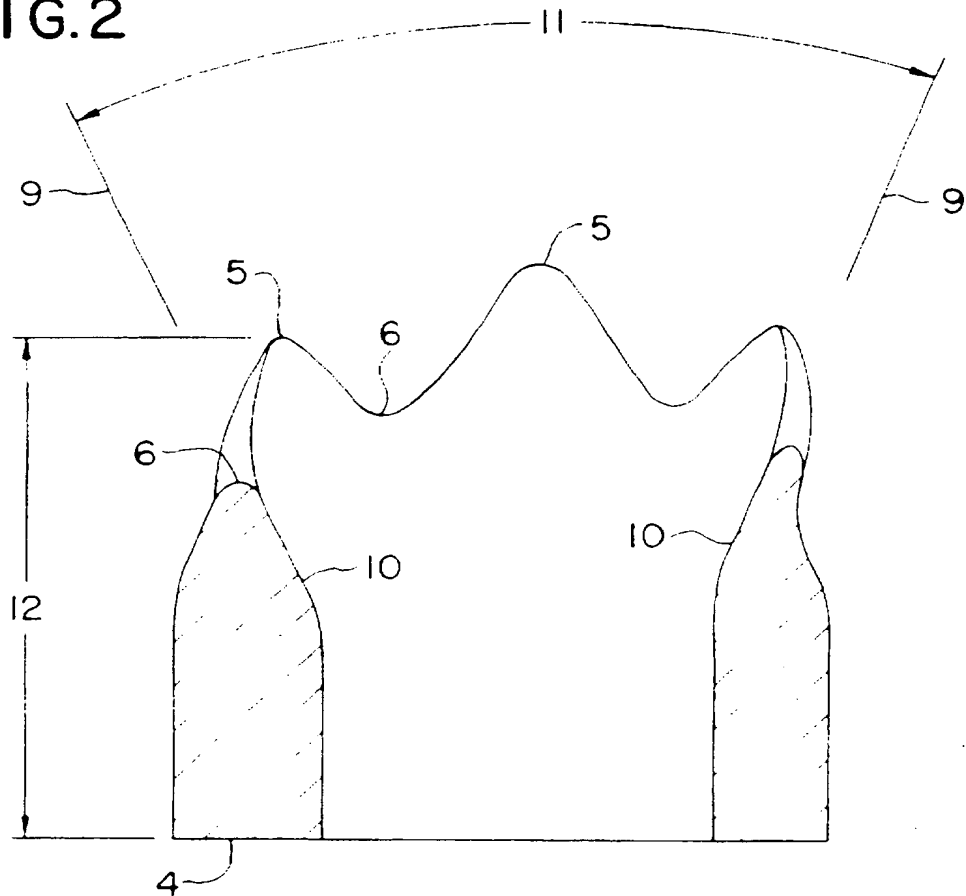
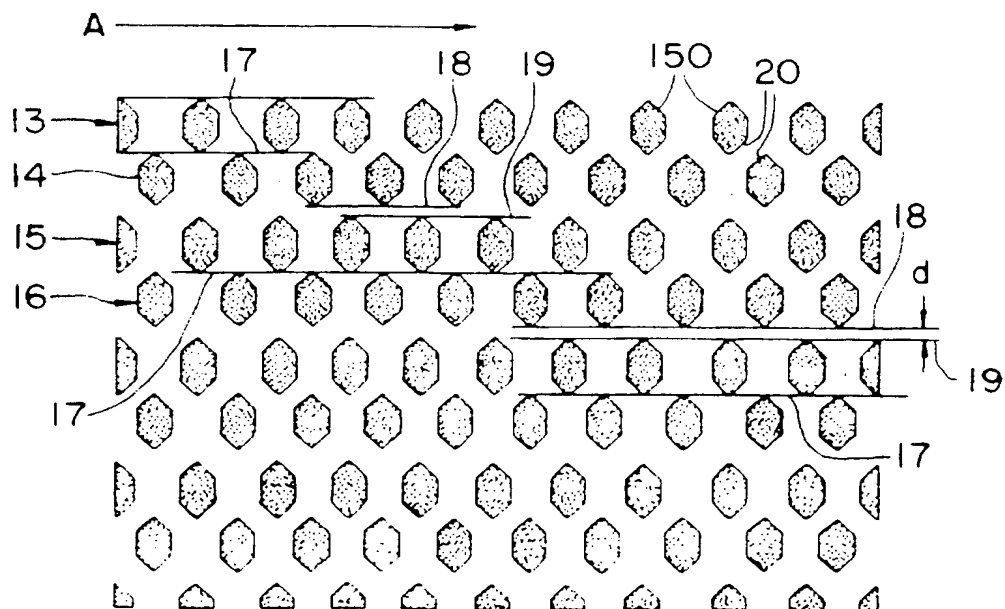
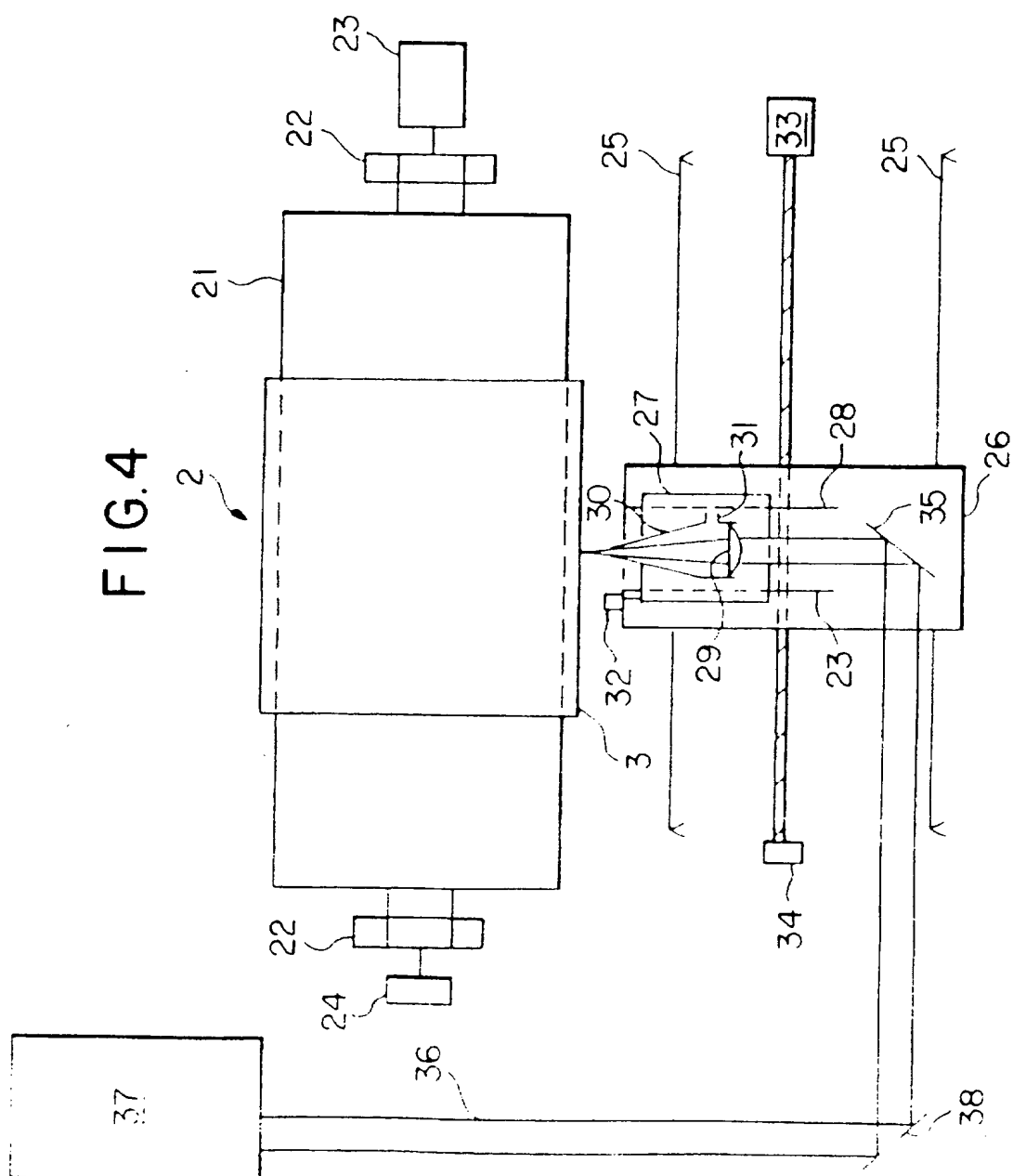


FIG.3

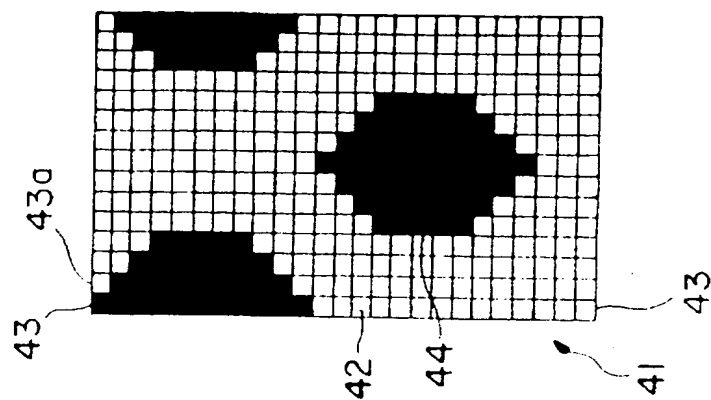


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FIG. 4

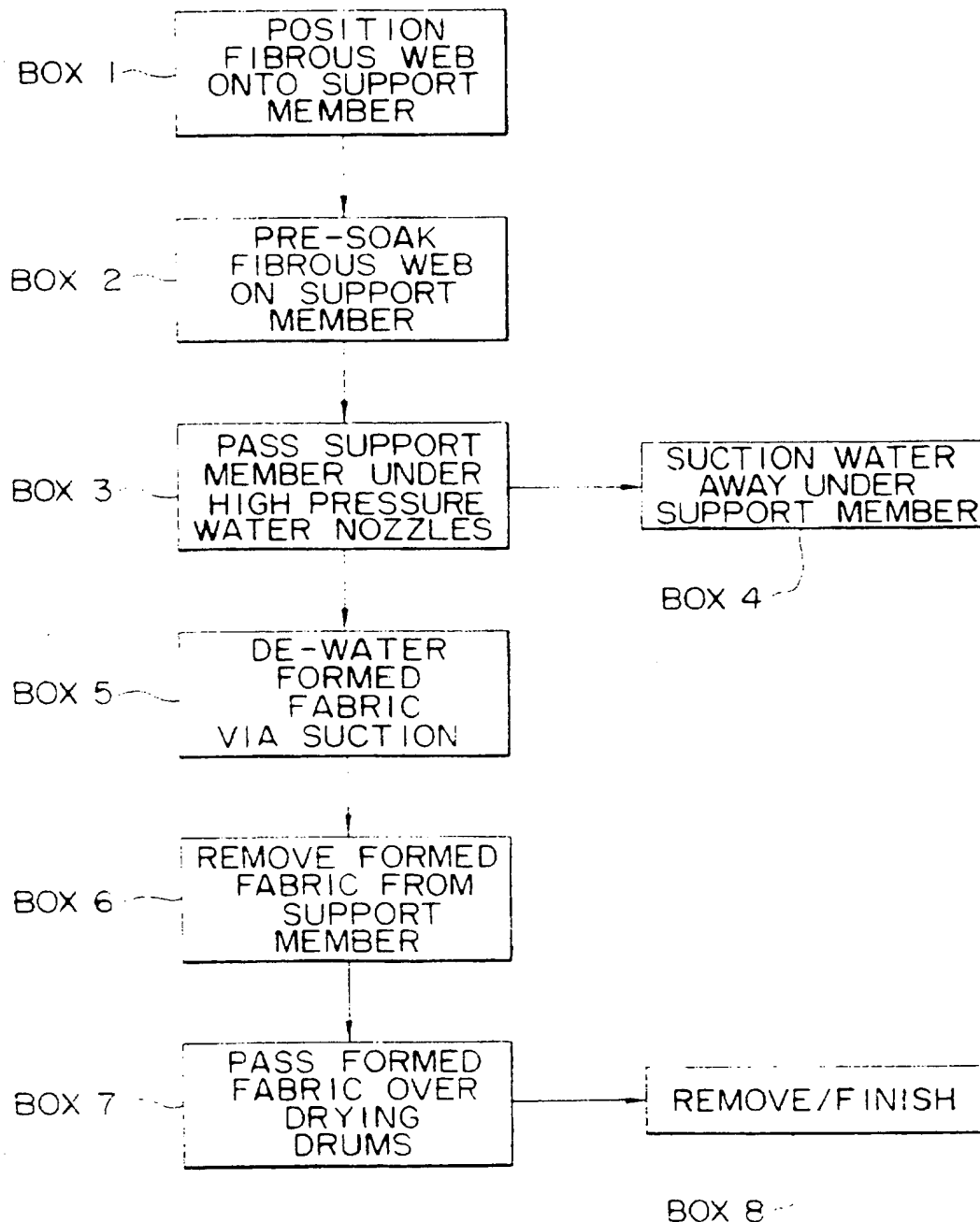


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FIG. 6



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FIG. 7

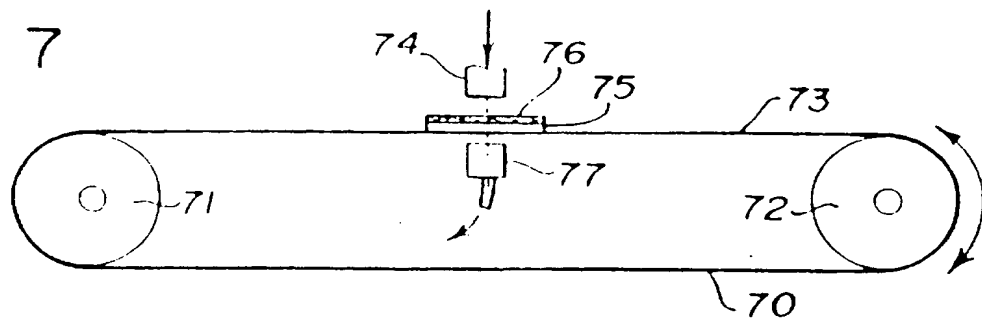


FIG. 8

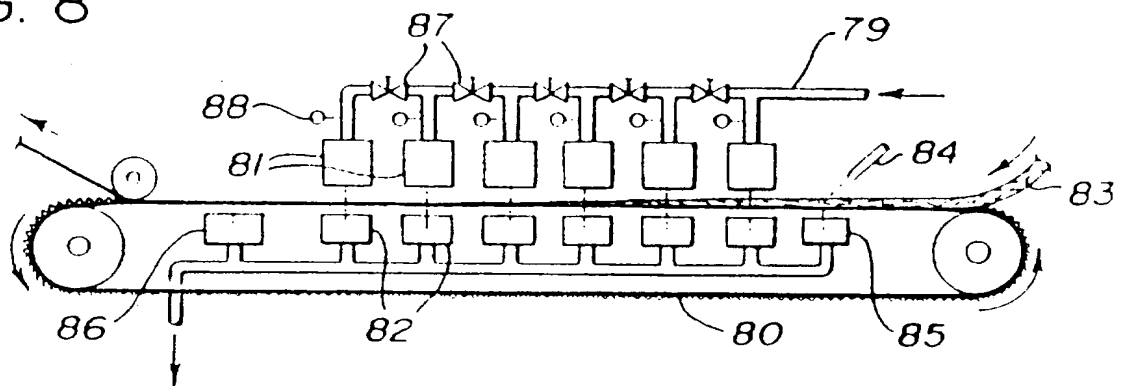
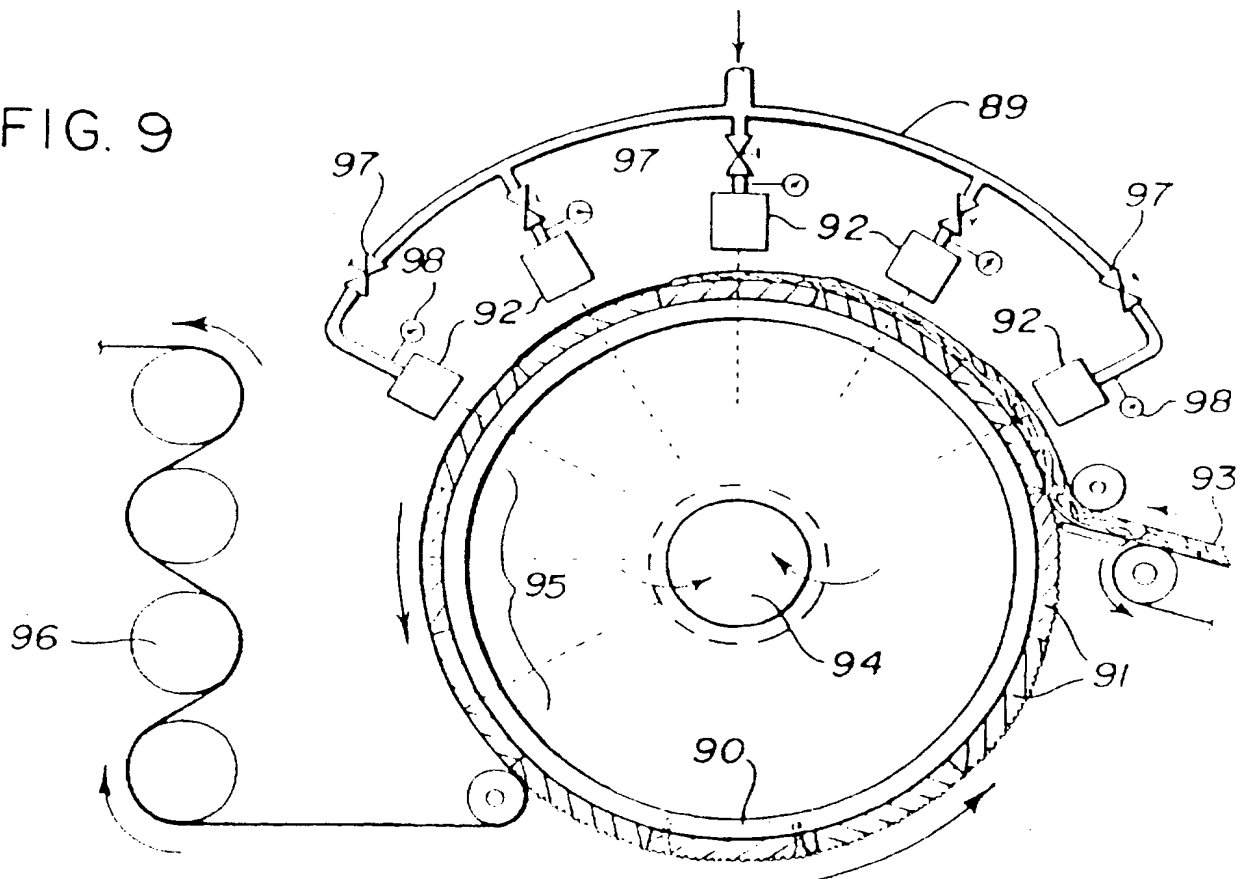
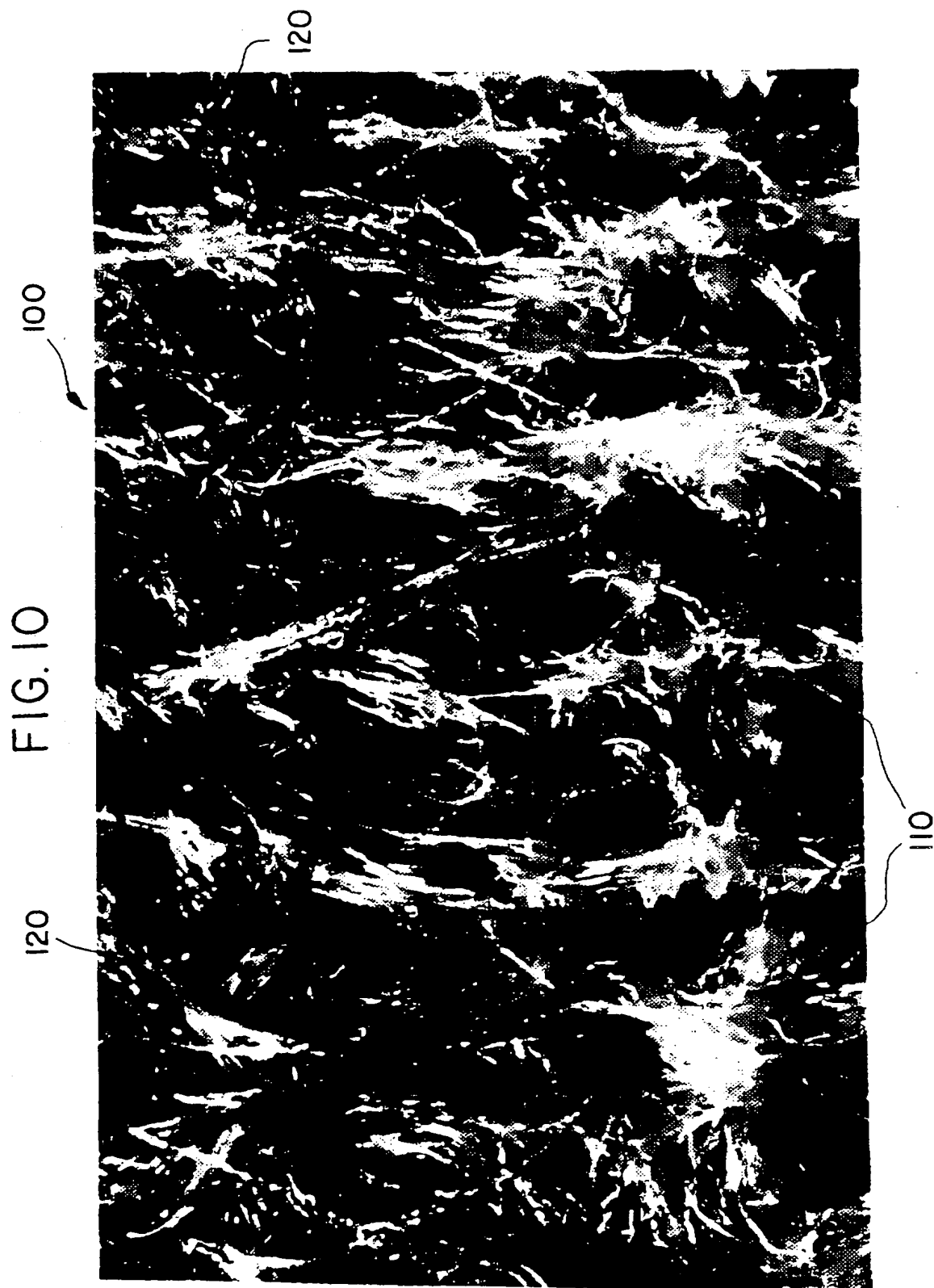


FIG. 9



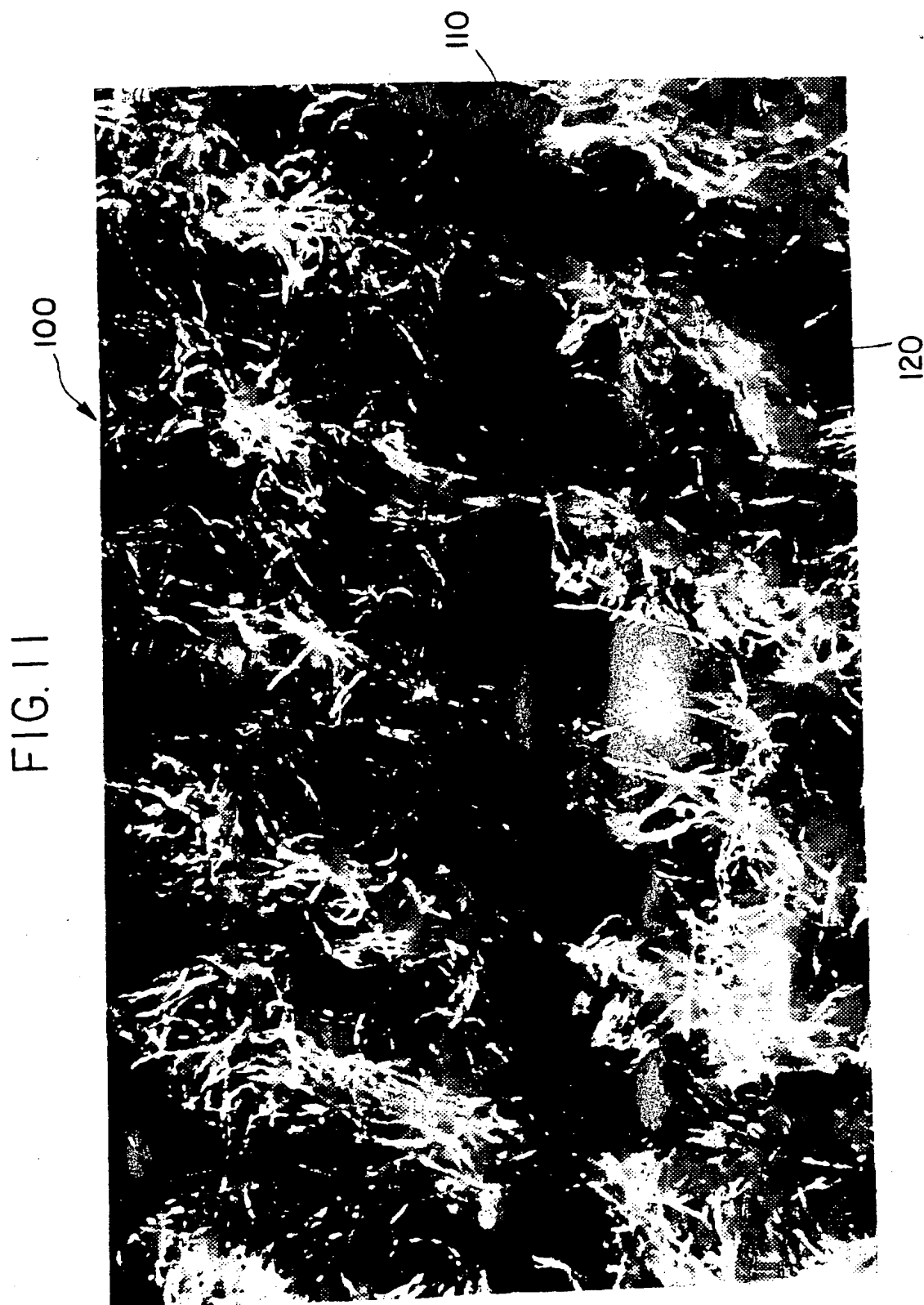
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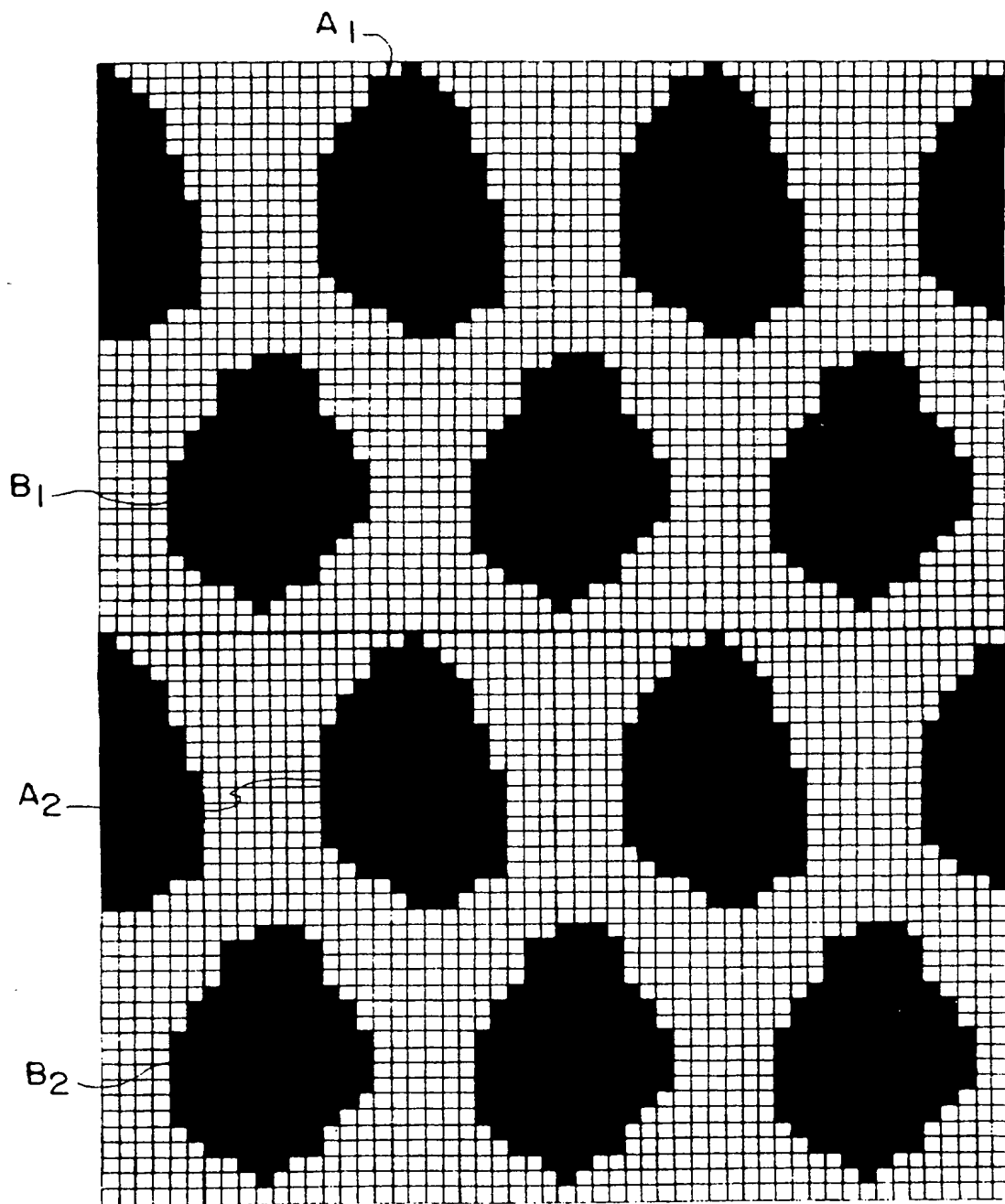


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FIG. 12



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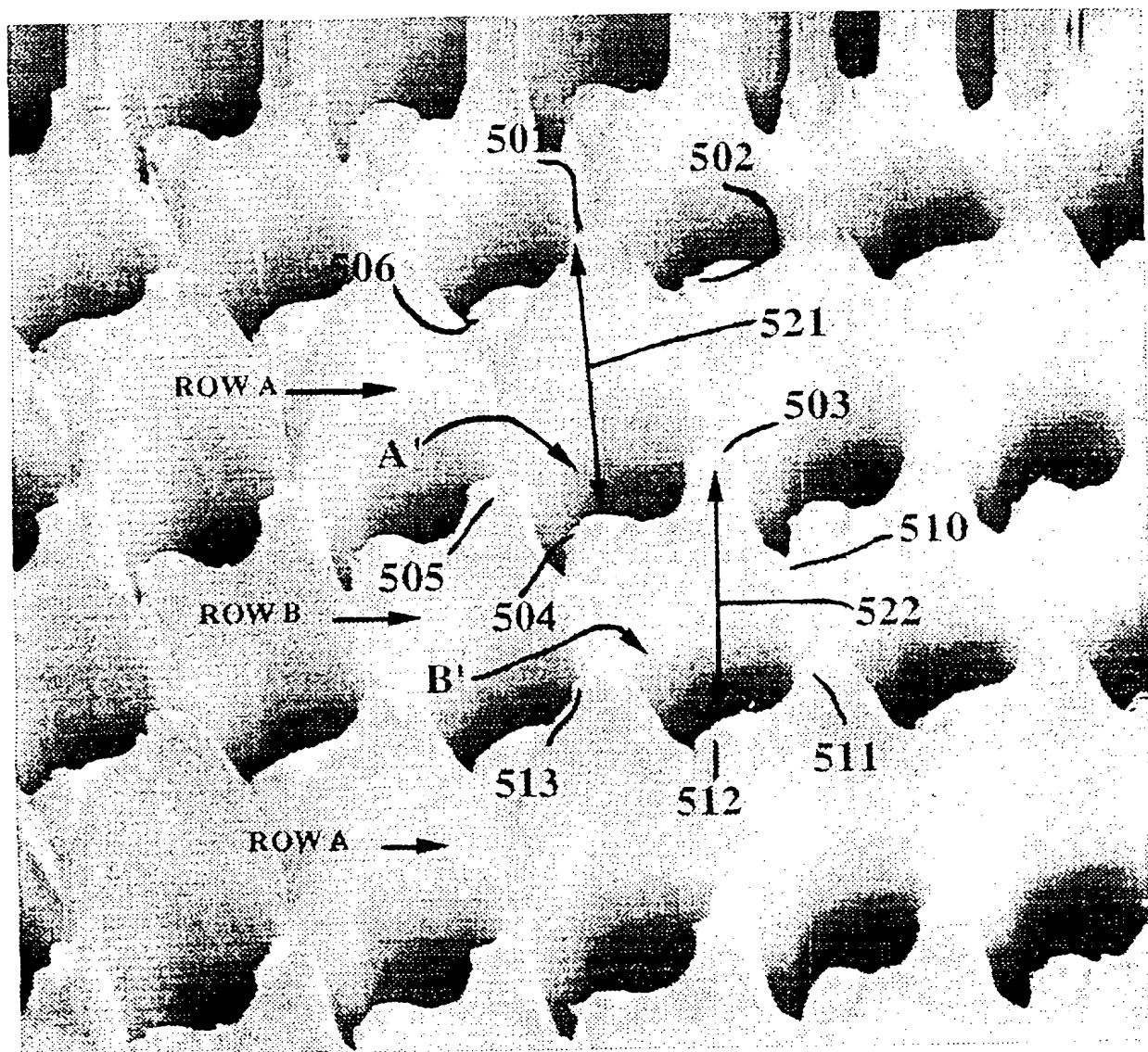


FIG. 13

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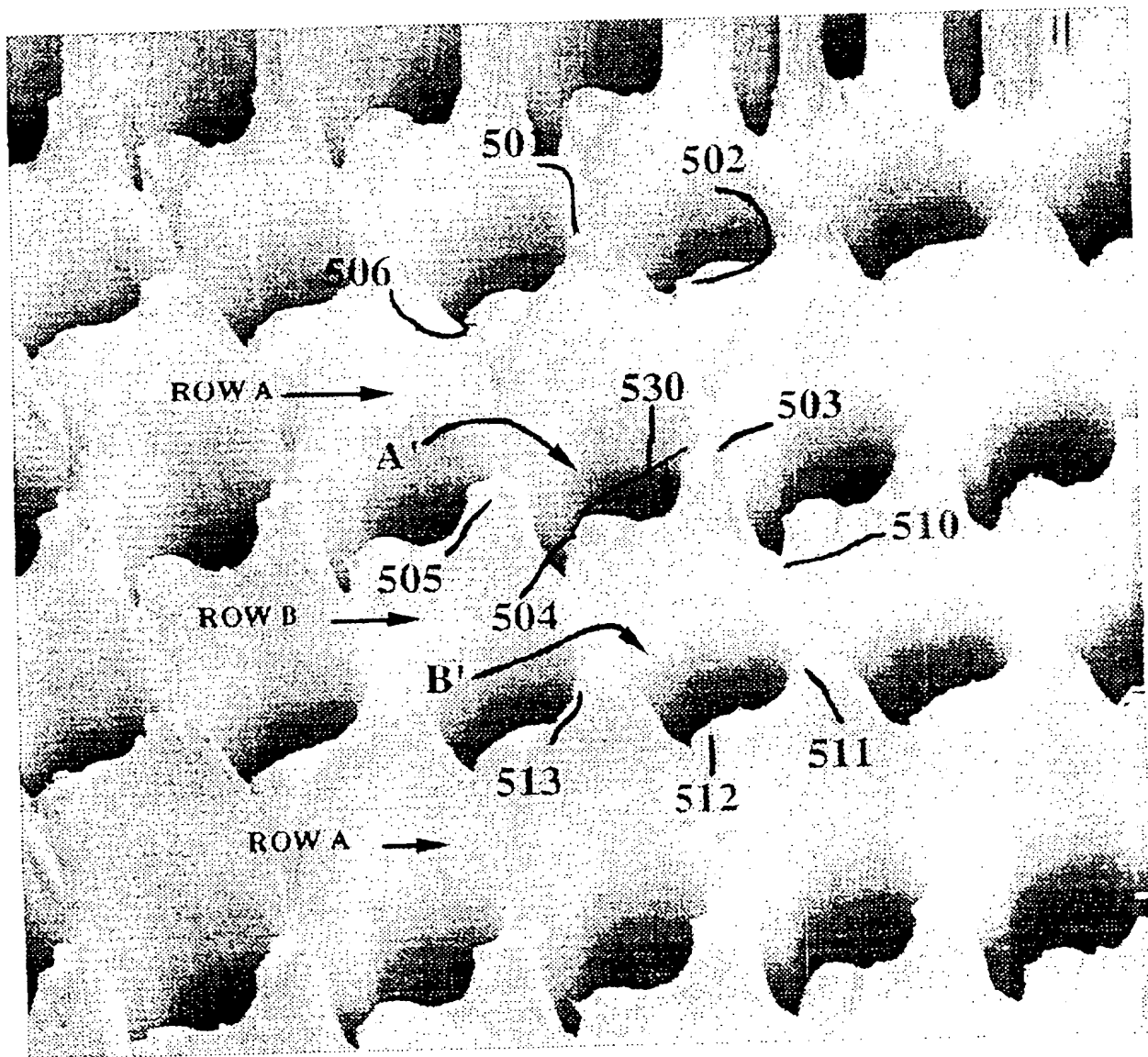
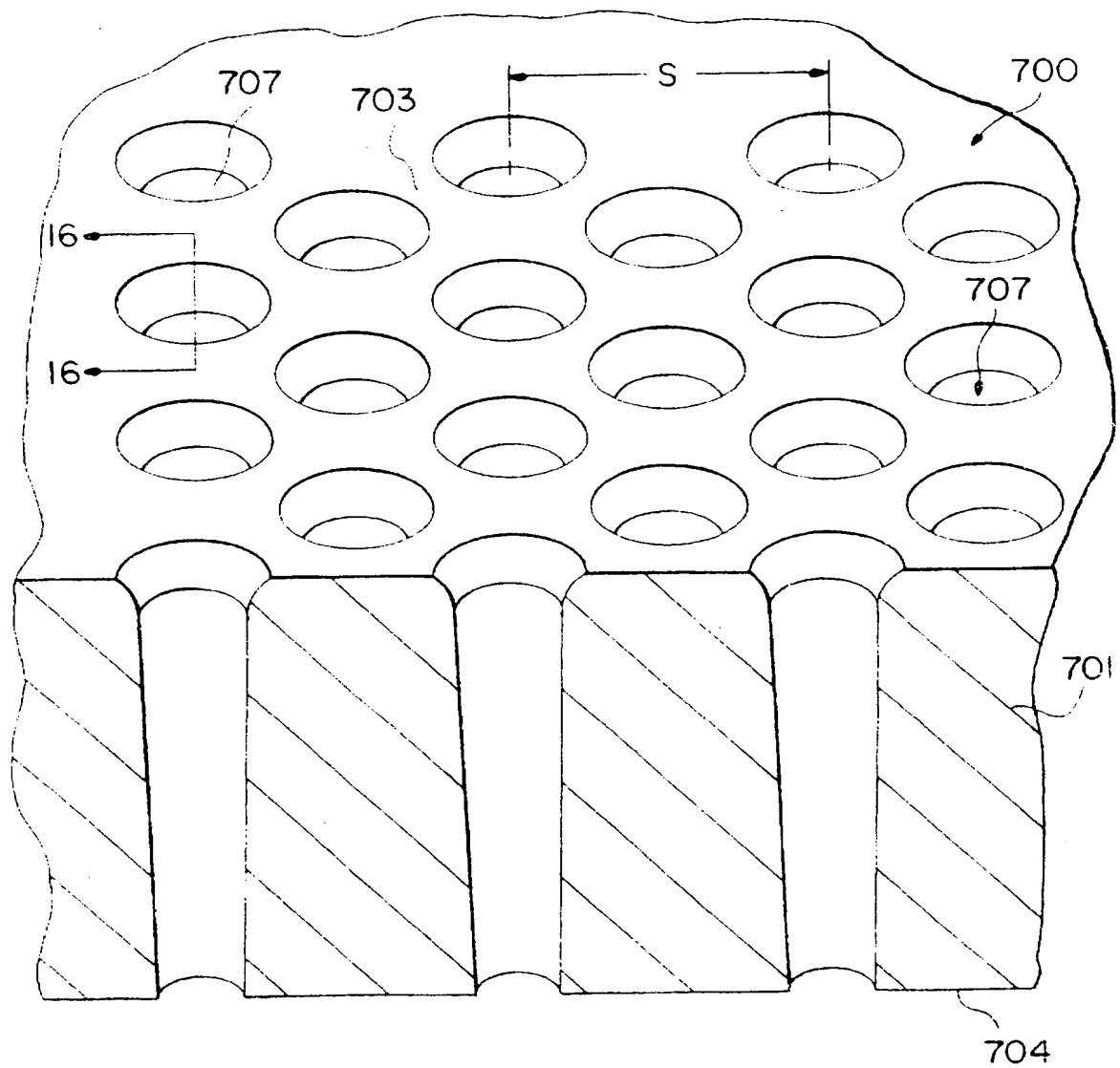


FIG. 14

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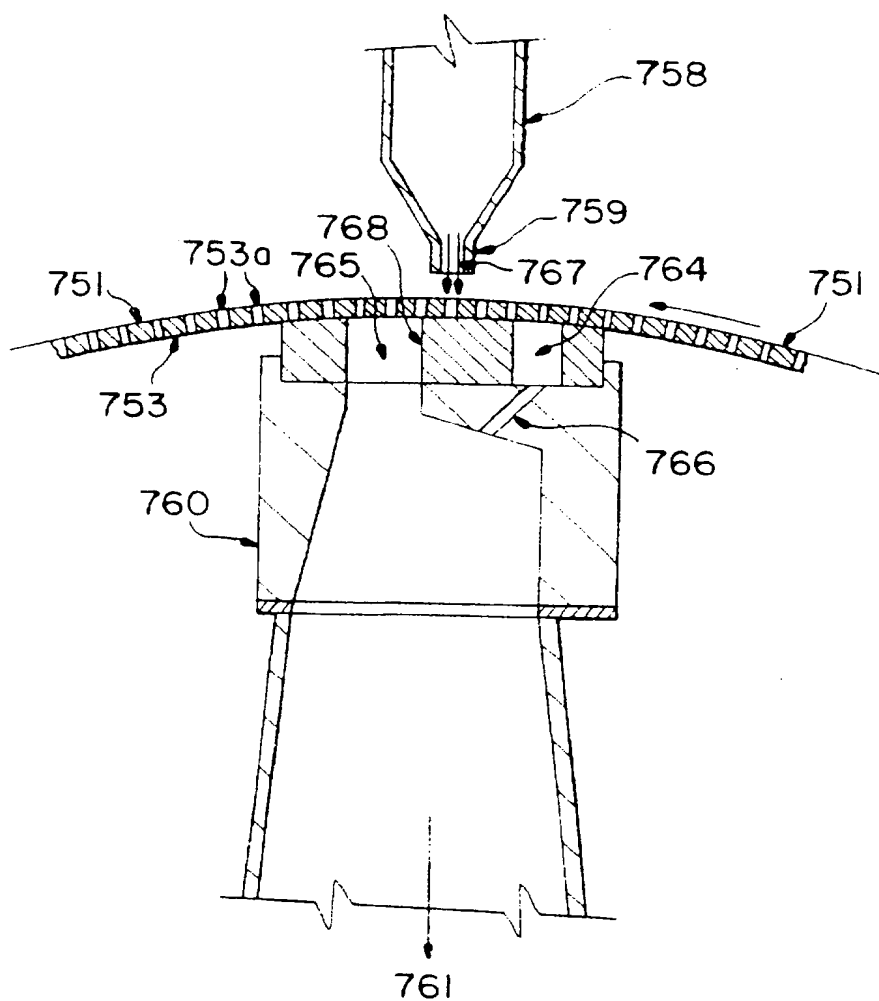
FIG. 15



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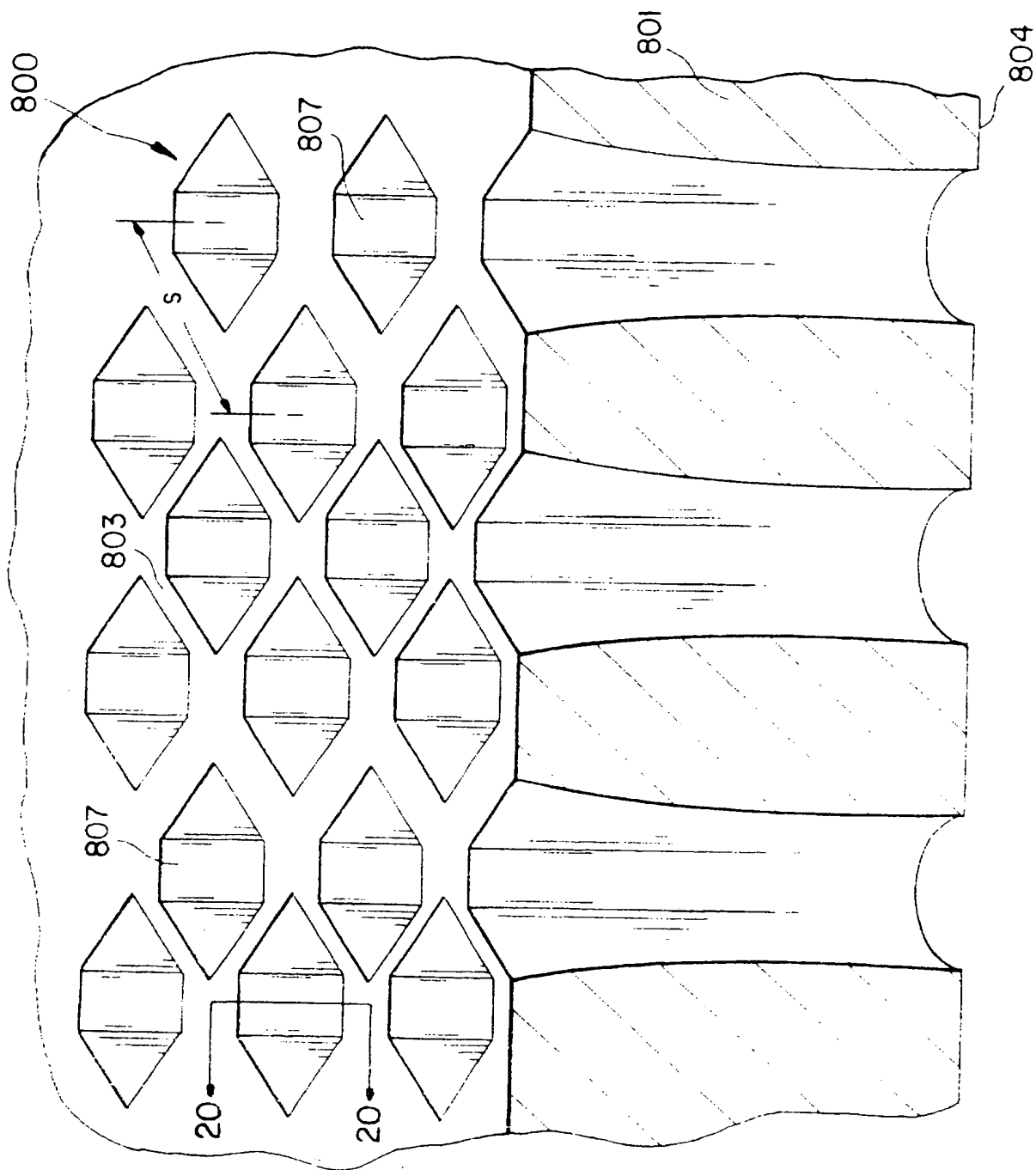
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FIG. 18



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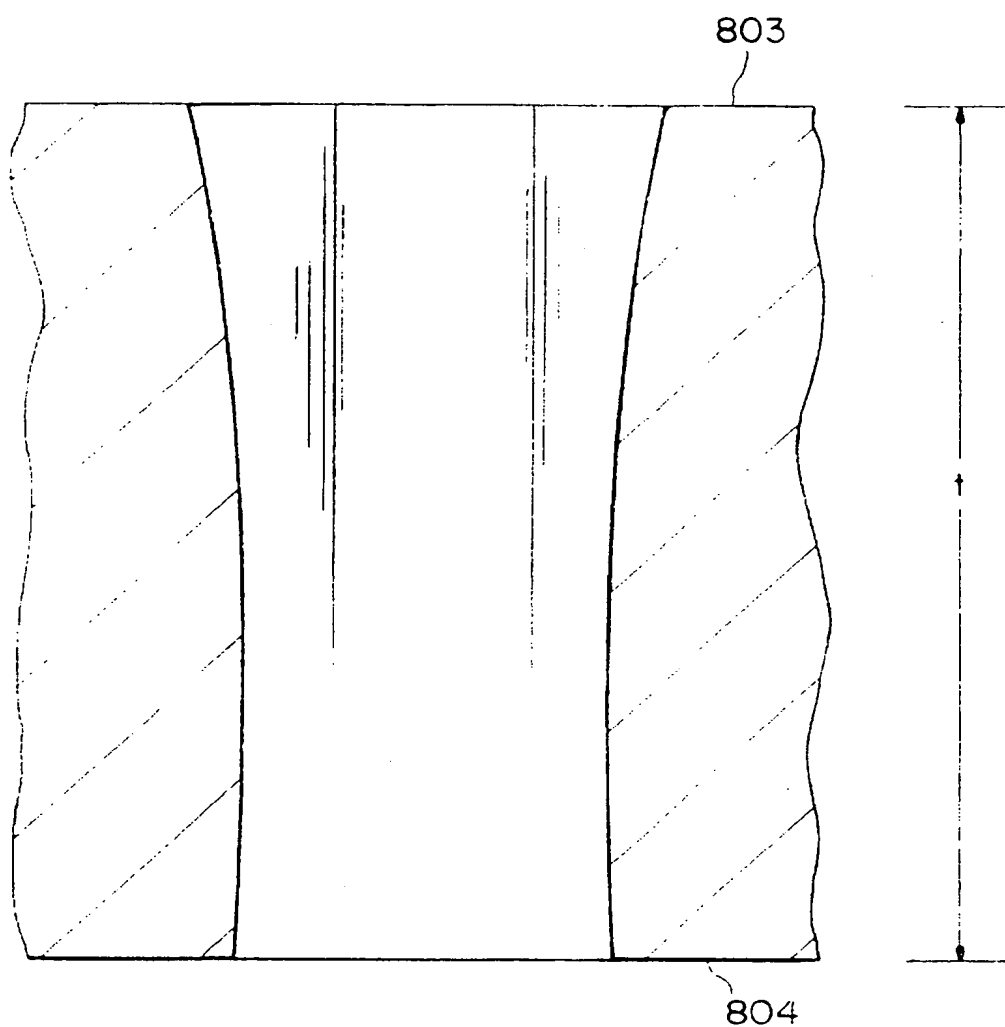
FIG.19



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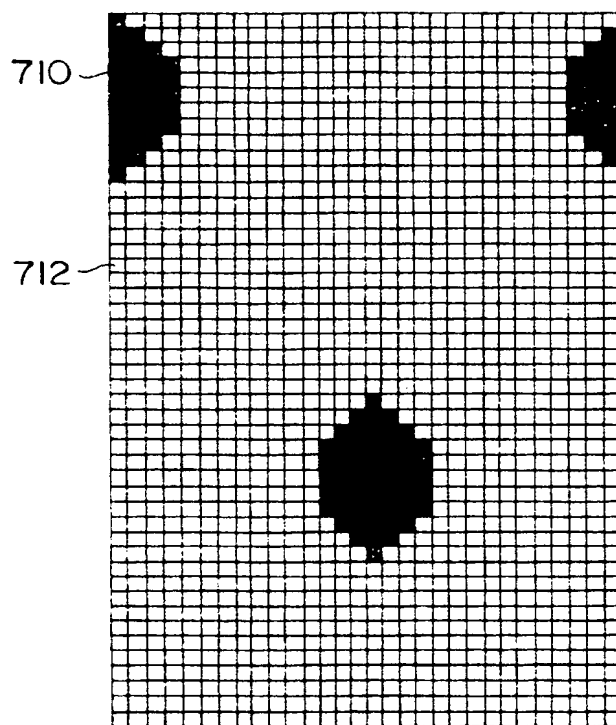
FIG. 20



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FIG. 21



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FIG.16

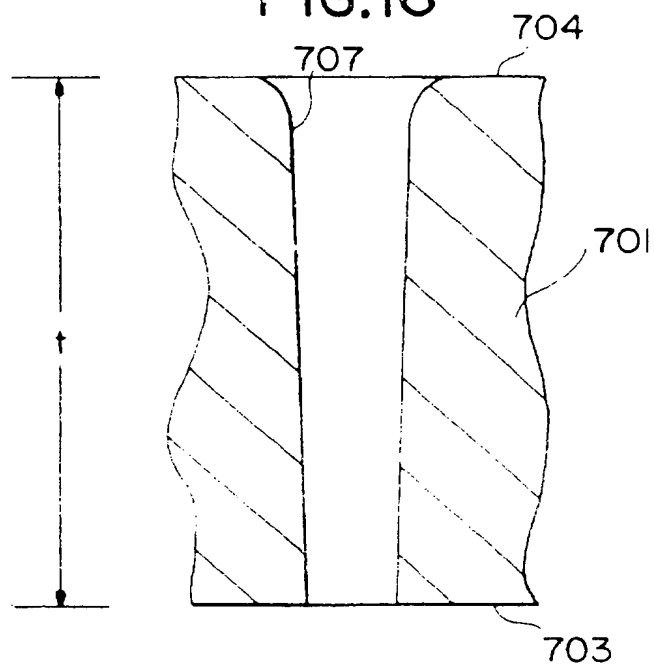
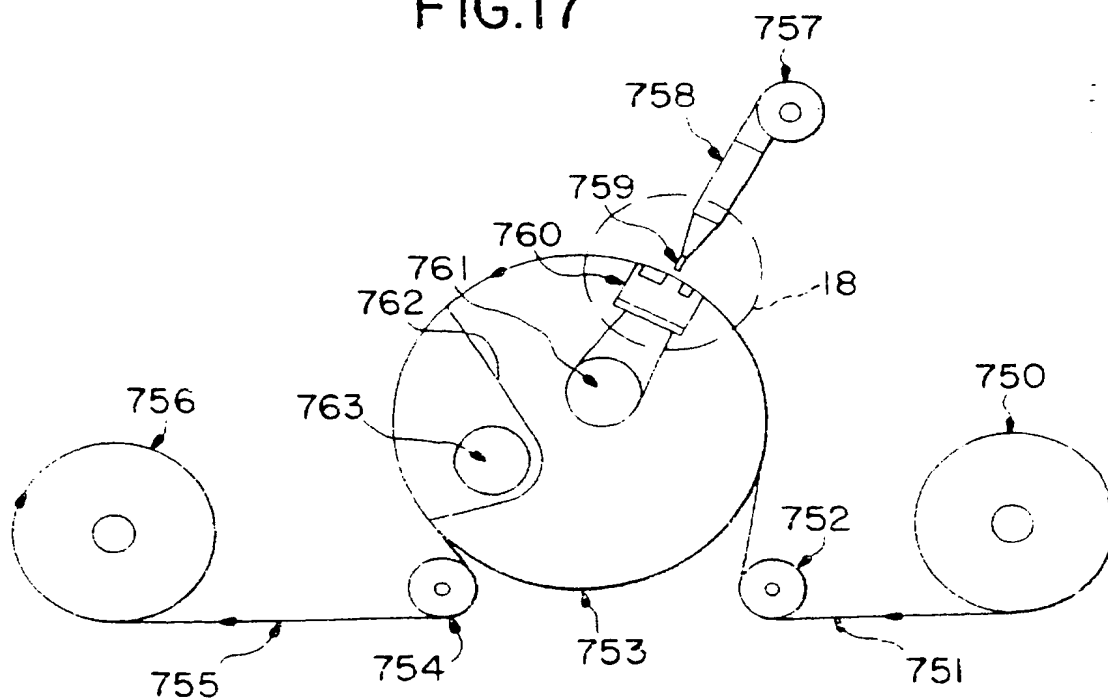


FIG.17



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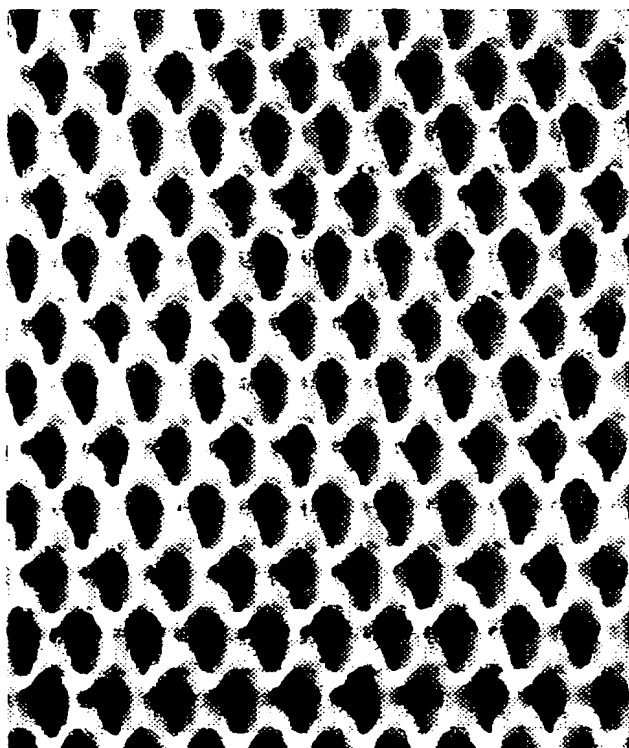


FIG. 22

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## INTERNATIONAL SEARCH REPORT

International Application No.

PCT/US 96/02728

A. CLASSIFICATION OF SUBJECT MATTER  
 IPC 6 B23K26/00 D04H1/46 B26F1/26

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 6 B23K D04H B26F

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
E	EP,A,0 701 877 (MCNEIL-PPC) 20 March 1996 see claim 1 ---	1
X	EP,A,0 127 192 (ETHYL CORPORATION) 5 December 1984 see claims 1-7 ---	14,20
A	EP,A,0 432 958 (THE BLACK CLAWSON) 19 June 1991 see abstract ---	1
A	GB,A,1 152 882 (GORDON ASHWORTH) 21 May 1969 see claims 1-20 -----	14-21

☐ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

## \* Special categories of cited documents:

- \* "A" document defining the general state of the art which is not considered to be of particular relevance
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- \* "O" document referring to an oral disclosure, use, exhibition or other means
- \* "P" document published prior to the international filing date but later than the priority date claimed

- \* "I" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
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- \* "&" document member of the same patent family

Date of the actual completion of the international search

5 November 1996

Date of mailing of the international search report

15.11.96

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Goovaerts, R

# INTERNATIONAL SEARCH REPORT

Information on patent family members

Inventor's Application No

PCT/US 96/02728

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